

GENERAL INFORMATION
General information

Color	White
Color shade	Off-white
Production process	Casting
Typology	Alpaca

Melting temperatures

Liquidus [°C]	935.0
Solidus [°C]	900.0
Melting range [°C]	35.0

Commercial composition

Copper (%)	55,00
Nickel (%)	9,00
Zinc (%)	36,00



FASHION line

FULL CHARACTERIZATION DATA
Color coordinates

L*	82.0
a*	-0.4
b*	13.0
c*	13.0
Yellow index	25.8

Physical characteristics

Density [g/cm ³]	8.4
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Product applications

Casting without stones
Casting in closed systems
Stone-in-place casting
Casting in open systems

Mechanical characteristics

As cast hardness [HV 0.2]	115.0
Hardness after annealing [HV 0.2]	150.0
Hardness after 70% area red. [HV 0.2]	250.0
Single step age-hardening hardness [HV 0.2]	120.0
Tensile strength (Rm) [Mpa]	488.0
Yield strength (Rp0.2) [MPa]	385.0
Elongation at rupture (A) [%]	22.0

CASTING PROCESSING PARAMETERS

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1035.0	1065.0
0.5 - 1.2 mm	580.0	650.0	1015.0	1035.0
> 1.2 mm	460.0	600.0	995.0	1015.0

Trees without stones

Let the flask cool down for 10-15 minutes, then quench in water.

Stone-in-place casting trees

Let the flask cool down for 30-45 minutes, then quench in water.

Pickling

Dip in RADIAL solution (50 g/l conc. at 60°C for 2 min.), or in sulphuric acid (10% conc. at 50°C for 5 min.)