

TECHNICAL DATA SHEET

PRIMA215 - 417 ‰

Master alloy for the production of white 375 - 417 - 585 - 750 ‰ gold jewellery obtained by investment casting. This product, thanks to its complex composition made of numerous different special elements, ensures an extreme level of deoxidation, an extreme surface quality, an enhanced fluidity and a long lasting of this features also after many reuses of casting scraps, making it the most advanced solution for castings with and without stones in place.

TAB.1 - Mechanical data

Hardness as cast	125	HV
Hardness hardened	n.d.	
Tensile strength	479	MPa
Yield strength	212	MPa
Elongation	40	%

TAB.2 - Physical data

Color	Standard white		
Colour Coordinates	L*	87.35	
	a*	1.71	
	b*	10.5	
Density	11.25	g/cm3	
Melting Range	Solidus:	954	°C
	Liquidus:	1002	°C

TAB.3 - Heat treatments

Solution annealing	675 20	°C min
Recrystallization Annealing	675 20	°C min
Hardening	n.d.	

TAB.4 - Investment casting parameters

Premelting temperature		1102	°C
Casting Temperature	Min:	1052	°C
	Max:	1152	°C
Water investment powder ratio		36-38	%
Flask temperature	Min:	450	°C
	Max:	700	°C
Quenching time without stones in place	Min:	5	min
	Max:	20	min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4:	20	%
	Temp:	50	°C
	Time:	50	min