

TECHNICAL DATA SHEET

PRIMA215 - 750 ‰

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	198	HV
Hardness hardened	n.d.	
Tensile strength	470	MPa
Yield strength	330	MPa
Elongation	41	%

TAB.2 - Physical data

Color	Off-white		
Colour Coordinates	L*	86.56	
	a*	3.65	
	b*	13.84	
Density	14.66	g/cm3	
Melting Range	Solidus:	896	°C
	Liquidus:	917	°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		1017	°C
Casting Temperature	Min: Max:	967 1067	°C °C
Water investment powder ratio		36-38	%
Flask temperature	Min: Max:	450 700	°C °C
Quenching time without stones in place	Min: Max:	5 20	min min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4: Temp: Time:	20 50 50	% °C min