

# TECHNICAL SPECIFICATIONS

# Heraeus

**Alloy Code: H-134      Colour: Yellow**

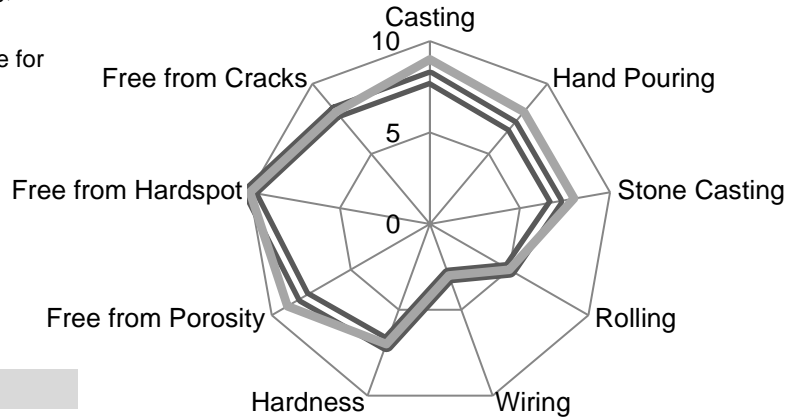
**Suitable Karatage:** 10/14K  
**Content :**      **Nickel:** 0.0%      **Palladium:** 0.0%  
                   **Silver:** 14.8%      **Platinum:** 0.0%

**Applications:** Suitable for loss wax casting, torch melting, stone casting

**Advantages:** Less porosity, high re-casting rate, suitable for Asian market

**Melting Range (°C):**

10K	875 - 882
14K	856 - 861



**CIELAB Value :**

Karat	YI:D1925	L*	a*	b*
10K	37.4	88.1	1.0	17.1
14K	37.9	84.5	1.2	17.2

Score(1--10)  
 1 means less likely to occur or not suitable  
 10 means most likely to occur or most suitable

**Recommended Casting Parameters :**      **(Quenching Time: 15 - 25 Minutes)**

Karat	Metal Casting Temperature (°C)	Vacuum-assisted Casting Investment Temperature (°C)		
		Thickness of work piece (mm)		
		Thin (0.2~0.5)	Medium (0.5~1.1)	Thick (>1.1)
10K	970-990	660-720	580-660	460-580
14K	950-970	660-720	560-640	440-560

**Tensile Properties :**

Karat	Annealed Hardness (HV)	As Casted Hardness (HV)	Max Strength (MPa)	Yield Strength (MPa)	Elongation (%)
10K	136	138	245	145	33
14K	136	139	296	176	36

**Technical Advice:**

- To avoid oxidation, the alloys must be covered with inert gas or yellow flame during casting.
- Not more than 50 % of old material should be used for recasting.
- The old material must be tumbled to remove the investment powder residue and oxides.  
The material is then pickled in dilute sulfuric acid (15 %) for 15 - 20 minutes to remove the rest of oxides.
- The sprue should be placed at the thickest position. Additional sprue must be applied if necessary.  
Fluted sprue is preferred to avoid any turbulence.

Remarks: The information is for your reference only. The parameters should be adjusted according to the particular casting conditions.  
 If you have any technical questions, please do not hesitate to contact us.