

TECHNICAL SPECIFICATIONS

Heraeus

Alloy Code:	H-136A	Colour:	Yellow
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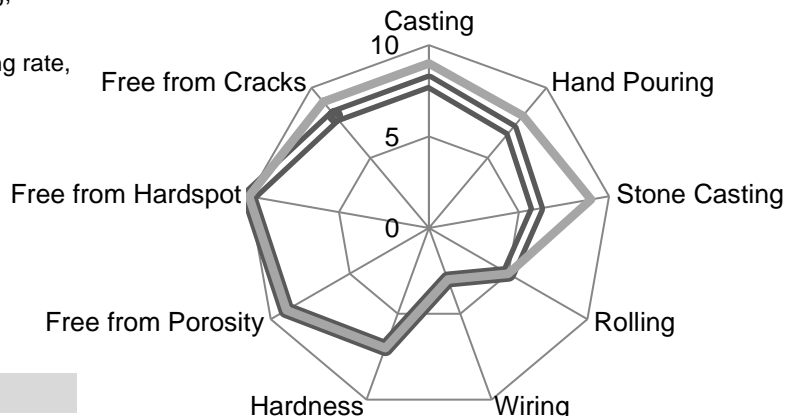
Suitable Karatage:	10/14K		
Content :	Nickel:	0.0%	Palladium: 0.0%
	Silver:	17.3%	Platinum: 0.0%

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

Advantages: Less porosity, low melt-loss, high re-casting rate, suitable for American market

Melting Range (°C):

10K	864 - 871
14K	854 - 862



CIELAB Value :

Karat	YI:D1925	L*	a*	b*
10K	36.4	85.4	-0.3	18.1
14K	37.0	84.9	-0.1	18.3

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	960-980	660-720	580-660	460-580
14K	945-965	660-720	560-640	440-560

Tensile Properties :

Karat	Annealed Hardness (HV)	As Casted Hardness (HV)	Max Strength (MPa)	Yield Strength (MPa)	Elongation (%)
10K	144	148	337	176	38
14K	155	158	331	191	36

Technical Advice:

1. To avoid oxidation, the alloys must be covered with inert gas or yellow flame during casting.
2. Not more than 50 % of old material should be used for recasting.
3. 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.
4. 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.

