TECHNICAL SPECIFICATIONS

Heraeus

Alloy Code: H-149CN Colour: White

Suitable Karatage: 14/18K

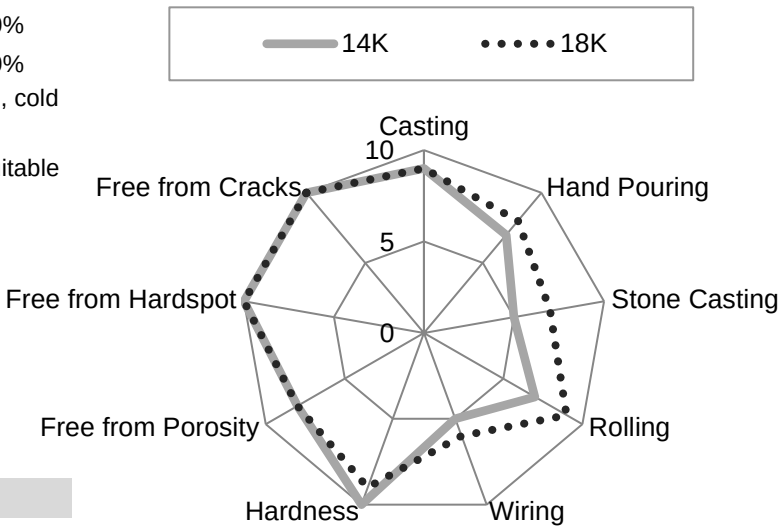
Content : **Nickel:** 28.0% **Palladium:** 0.0%
Silver: 0.0% **Platinum:** 0.0%

Applications: Suitable for loss wax casting, hand-making, cold working

Advantages: Extra white, less porosity, low melt-loss, suitable for CNC milling

Melting Range (ºC):

14K	942 - 965
18K	904 - 919



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

CIELAB Value :

Karat	YI:D1925	L*	a*	b*
14K	18.0	85.0	-0.3	8.9
18K	23.6	85.8	0.9	11.5

Recommended Casting Parameters : (Quenching Time: 15 – 25 Minutes)

Karat	Metal Casting Temperature (ºC)	Vacuum-assisted Casting Investment Temperature (ºC) Thickness of work piece (mm)		
		Thin (0.2~0.5)	Medium (0.5~1.1)	Thick (>1.1)
14K	1050-1070	680-720	600-680	550-600
18K	1030-1050	680-720	600-680	550-600

Tensile Properties :

Karat	Annealed Hardness (HV)	As Casted Hardness (HV)	Max Strength (MPa)	Yield Strength (MPa)	Elongation (%)
14K	210	212	588	173	35
18K	207	209	586	207	28

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.

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