

TECHNICAL SPECIFICATIONS

Master Alloy : H-155R

Suitable karatage : 10/14/18K	Colour : Light Pink
Nickel Content : 0 %	Silver Content : 36 %
Palladium Content : 0 %	Platinum Content : 0 %
Hardness : 162HV (18K)	
Applications : Suitable for loss wax casting, torch melting, machining	
Advantages : Shiny, not easily cracked, high re-casting rate	

Recommended Casting Parameters :

Metal Casting Temperature	: 10K / 1075 °C, 14K / 1020 °C, 18K / 1000 °C
Investment Temperature	: 540 – 650 °C (Vacuum-assisted Casting)
	: 430 – 530 °C (Centrifugal Casting)
Quenching Time	: 10 – 15 minutes

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 pickled in dilute sulfuric acid (10 %) for 15 - 20 minutes to remove the oxide, followed by tumbling to remove the investment powder residue.
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.

Main Office:
Heraeus Ltd.
 Heraeus Technology Centre
 30 On Chuen Street, On Lok Tsuen
 Fanling, N.T., Hong Kong
 Tel : (852) 2675 1200
 Fax: (852) 2682 3220

總公司:
賀利氏有限公司
 香港新界粉嶺安樂村
 安全街 30 號
 賀利氏科技中心
 電話 : (852) 2675 1200
 傳真 : (852) 2682 3200

Hunghom Sales Office:
Heraeus Ltd.
 Rm. 2111-3, Peninsula Square
 18 Sung On Street, Hunghom
 Kowloon, Hong Kong
 Tel : (852) 2773 1733
 Fax: (852) 2773 1090

紅磡營業部:
賀利氏有限公司
 香港九龍紅磡
 崇安街 18 號
 半島廣場 2111-3 室
 電話 : (852) 2773 1733
 傳真 : (852) 2773 1090