

TECHNICAL DATA SHEET

DIVINA812 - 585 ‰

Master alloy for the production of white nickel and palladium free 585 - 750 ‰ gold jewellery obtained by investment casting. The extreme low melting range of the alloys obtained with this product makes the castings, especially with stone-in-place, very easy and stable, erasing any problem of surface defects due to gas porosity and stone (diamonds included) cracking or damaging.

TAB.1 - Mechanical data

Hardness as cast	135	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	white
Colour Coordinates	L*: 86.37 a*: 1.43 b*: 10.78
Density	12.25 g/cm ³
Melting Range	Solidus: 400 °C Liquidus: 602 °C

TAB.3 - Heat treatments

Solution annealing	300 °C 30 min
Recrystallization Annealing	300 °C 30 min
Hardening	n.d.

TAB.4 - Investment casting parameters

Premelting temperature		702	°C
Casting Temperature	Min: Max:	652 752	°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