

TECHNICAL DATA SHEET

SPARK594T

Alloy for the production of bronze items, jewels and models obtained by investment casting. The elements contained in this product ensure a high deoxidation after casting and a high surface quality, making it suitable for castings with and without stones in place.

TAB.1 - Mechanical data

Hardness as cast	129	HV
Hardness hardened	151	HV
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	pink
Colour Coordinates	L*: 85.68 a*: 5.97 b*: 17.43
Density	8.70 g/cm ³
Melting Range	Solidus: 934 °C Liquidus: 998 °C

TAB.3 - Heat treatments

Solution annealing	701 30	°C min
Recrystallization Annealing	701 30	°C min
Hardening	n.d.	

TAB.4 - Investment casting parameters

Premelting temperature		1098	°C
Casting Temperature	Min: Max:	1048 1148	°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