

## TECHNICAL DATA SHEET

### SPARK598 - Au2kt

Brass for the production of 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	100 HV
Hardness hardened	n.d.
Tensile strength	n.d.
Yield strength	n.d.
Elongation	n.d.

TAB.2 - Physical data

Color	Deep red
Colour Coordinates	L*: 88.80 a*: 5.24 b*: 17.41
Density	9.92 g/cm <sup>3</sup>
Melting Range	Solidus: 930 °C Liquidus: 980 °C

TAB.3 - Heat treatments

Solution annealing	670 °C - 30 min
Recrystallization Annealing	n.d.
Hardening	n.d.

TAB.4 - Investment casting parameters

Premelting temperature	1080 °C
Casting Temperature	Min: 1030 °C Max: 1130 °C
Water investment powder ratio	36 - 38 %
Flask temperature	Min: 450 °C Max: 700 °C
Quenching time without stones in place	Min: 5 min Max: 20 min
Quenching time with stones in place	15 min in boiling water
Pickling	H <sub>2</sub> SO <sub>4</sub> : 20 % Temp: 50 °C - 5 min