OG445C

Technical chart

Last revision
19/08/2009

YELLOW ALLOY FOR 9-14 KT CASTING

Title **14** Colour **Yellow** [L: 85,6 a: 1,7 b: 18,4 c:]

Product description

OG445C is a soft yellow alloy for lost wax casting. This is a versatile product which possesses an excellent quality:price ratio. Offers compact surfaces and reduced shrinkage porosity. Possesses antioxidant properties and good fluidity.

Recommended applications

OG455C is an alloy for lost-wax casting, designed specifically for open systems. If a more yellow-greenish colour is required, the alloy composition can be modified with the addition of silver, according to the following ratio: Au: 585 / Ag: 75 / OG445C: 340. After this modification, liquidus temperature (Tliq.) will be about 870°C. Casting and graining temperatures reported in this technical sheet will be consequentely reduced of about 20°C.

Physical-chemical properties

Precious metal of reference

Ag 3,0%

Temperatures (°C)

Solidus	855
Liquidus	890
Range	35

Density (g/cm³) 12,7

Mechanical characteristics

Tensile strength (Rm) [N/mm²]	
Yield strength (Rp0.2) [N/mm²]	
Elongation (A) [%]	
"As cast" hardness [HV 0.2]	118
Hardness after 70% red. [HV 0.2]	255
Hardness after annealing [HV 0.2]	

Via San Benedetto, n. 14/34 - Z.I. 36050 Bressanvido (Vicenza) Italy - Tel. +39 0444 467911 - Fax +39 0444 660677 www.legorgroup.com Customer Service: infotech@legor.com

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Instructions for use

Casting

Graining temperature (°C) 1010

Casting temperatures

Size of objects	Metal casting (°C)	Flask (°C)
thin from 0,2 to 0,5 mm.	1020-990	660-720
medium from 0,5 to 1,2 mm	990-970	580-650
thick > 1,2 mm.	970-950	460-600

Flasks quenching

Leave flask to air cool for 10-18 minutes, then quench in warm water

Pickling

Dip items in RADIAL (50g/l) cleaning solution, 60°C for 2 minutes, or in a 10% sulfuric acid solution, 50°C for 5 minutes

Notes

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