



Firstray Ventures

Master Alloy for Gold, Silver & Imitation Jewellery

ALLOY CODE: - CG912YCR

Carat : 9 - 14	Color : Yellow	Melting Temp of Alloy :1020 °C
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Application: The alloy CG912YCR is the most widely used alloy for low carat jewelry. It imparts yellow color. It is usable from 9 to 14 carat Investment cast jewelry (sania, kati, nose pin). It ensures smooth surface finish and porosity-free finished products. Reusability of the castings is also very satisfactory.

	<u>9K</u>	<u>14K</u>
Application	Casting	Casting
Alloying Temp.	1040°C - 1050°C	1050°C - 1060°C
Casting Temp.	1040°C - 1050°C	1050°C - 1060°C
Flask Temp. [Normal Cast]	650°C - 660°C	660°C - 670°C
Quenching Time	10 - 12 minutes	10 - 12 minutes

Notes:

- The actual casting temperatures and flask temperatures shall be decided by the parameters like the section thickness of the items (thick, medium or thin), the overall size/bulk of the cast tree, the design intricacies etc.
- As a thumb rule, for thinner sections higher temperatures are selected and for thicker sections lower temperatures are preferred. At the same time, designs demanding higher form filling capabilities, higher than normal temperatures are an obvious choice.
- For reusing the castings we recommend 50% fresh carat gold with 50% castings.