



Firstray Ventures

Master Alloy for Gold, Silver & Imitation Jewellery

ALLOY CODE : - CL18RC

Carat: 14 – 18	Color: Rose Pink	Melting Temp of Alloy: 1030 °C
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Application : The alloy CL18RC is the most widely used alloy for rose gold jewelry. It imparts rose pink color that is very popular market. It is usable from 9 to 18 carat investment cast jewelry. It ensures smooth surface finish and porosity-free finished products. Reusability of the castings is also very satisfactory.

	<u>14 K</u>	<u>18 K</u>
Application	Casting	Casting
Alloying Temp.	1090°C – 1100°C	1100°C – 1120°C
Casting Temp.	1060°C – 1070°C	1070°C – 1080°C
Flask Temp. [Normal Cast]	660°C – 670°C	670°C – 680°C
Flask Temp. [Stone Cast]	640°C – 660°C	660°C – 670°C
Quenching Time	3 – 4 minutes	1 – 3 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.
- The 18 carat castings have a tendency to get hardened and subsequently give problems of cracking especially when flasks are cooled very slowly. For this reason, it is recommended that the flasks are cooled as fast as permitted by the quality of diamonds and also by the design parameters.
- For reusing the castings, we recommend 70% fresh carat gold with 30% castings.