

**MASTER  
ALLOY**
**BR10**

BRASS FOR CASTING

**GENERAL INFORMATION**
**General information**

Typology	Brass
Color	Yellow
Color shade	Pinkish yellow
Production process	Casting
Grain refinement level	Low
Deoxidation level	Very high

**Commercial composition (%)**

CU	92.0
ZN	4.0
SI	4.0

**Melting Temperatures**

Solidus [°C]	880.0
Liquidus [°C]	985.0
Melting range [°C]	105.0

**FULL CHARACTERIZATION DATA**
**Color coordinates**

L *	a*	b*	c*	Yellow Index
85.5	3.3	13.5	13.9	

**Mechanical characteristics**

As cast hardness [HV 0.2]	125.0
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**Physical characteristics**

Density [g/cm <sup>3</sup> ]	8.6
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**Product applications**

Stone-in-place casting  
 Casting in closed systems  
 Casting in open systems

**CASTING PROCESSING PARAMETERS**
**Pre-melting temperature**

Temperature [°C] 1105

**POURING TEMPERATURES**

	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1085	1115
0.5 - 1.2 mm	580	650	1065	1085
> 1.2 mm	460	600	1045	1065

**Trees without stones**

Let the flask cool down for 5 minutes, then quench it in water.

**Stone-in-place casting trees**

Let the flask cool down for 30-45 minutes, then quench it in water.

**Pickling**

Dip in RADIAL solution (50 g/l conc. at 60°C) for 2 minutes, or in sulphuric acid (10% concentration at 50°C) for 5 minutes.