

TECHNICAL DATASHEET AND GUIDELINE

OTTGR
Title

Brass for casting

GENERAL INFORMATION

Typology	Brass
Production process	Casting
Color	Yellow
Color shade	Light yellow
Density (g/cm ³)	8.5
Melting temperatures	
Solidus (°C)	835
Liquidus (°C)	940

Commercial composition	
Cu (%)	84
Si (%)	3
Zn (%)	13



FULL CHARACTERIZATION DATA

General characteristics	
Fluidity (grid filling test) [%]	90
Color coordinates	
L*	85.7
a*	1.2
b*	14.3
c*	14.4

Mechanical characteristics	
As cast hardness [HV 0.2]	130
Single step age-hardening hardness [HV 0.2]	150

PRODUCT APPLICATIONS

Casting in open systems
Casting in closed systems
Casting without stones

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Casting temperatures	Metal - from (°C)	Metal - to (°C)	Flask - from (°C)	Flask - to (°C)
Thin (below 0.5 mm)	1040	1070	660	720
Medium (from 0.5 to 1.2 mm)	1020	1040	580	650
Thick (above 1.2 mm)	1000	1020	460	600

Trees without stones

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

Stone-in-place casting trees

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

Pickling

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