

TECHNICAL DATASHEET AND GUIDELINE

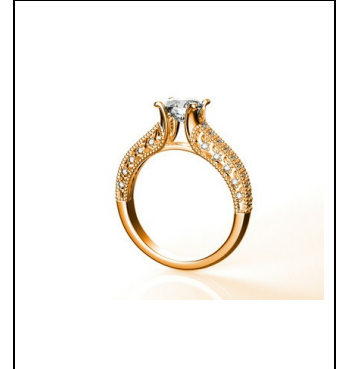
BR10
Title

Brass for casting

GENERAL INFORMATION

Typology	Brass
Production process	Casting
Color	Yellow
Color shade	Pink yellow
Density (g/cm ³)	8.6
Melting temperatures	
Solidus (°C)	880
Liquidus (°C)	985

Commercial composition	
Cu (%)	92.5
Si (%)	3.5
Zn (%)	4



FULL CHARACTERIZATION DATA

General characteristics	
Fluidity (grid filling test) [%]	47
Color coordinates	
L*	85.5
a*	3.3
b*	13.5
c*	13.9

Mechanical characteristics	
As cast hardness [HV 0.2]	125

PRODUCT APPLICATIONS

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

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CASTING PROCESSING PARAMETERS

Casting temperatures	Metal - from (°C)	Metal - to (°C)	Flask - from (°C)	Flask - to (°C)
Thin (below 0.5 mm)	1085	1115	660	720
Medium (from 0.5 to 1.2 mm)	1065	1085	580	650
Thick (above 1.2 mm)	1045	1065	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.)