



INVESTMENT CASTING WITH 18K Ni WHITE GOLD

GR18W601000



Imperial's 18K Nickel White formulation is a time proven nickel white gold widely used for high end jewellery designs. The 18K Ni-White casting grain has been formulated to include carefully chosen grain refiners and deoxidizers that offer superior casting characteristics and increased ductility for settings, while maintain its unmistakable white colour.



18K white casting grain was graded in the "Superior" range (GRADE 1) according to the new standard for whiteness established by the World gold Council and MJSA. Visit www.imperialproducts.com/quality for more information regarding white gold classification



CASTING INFORMATION

1. **Melting range:** *916 – 948°C / *1680 – 1740°F
2. **Density:** 14.71 grams/cm³, 155.9 dwt/in³
3. **Recommended Casting and Flask Temperatures:** These vary with the design and mass of the item(s) being cast, so you may need to run some test casts to work out the combination of temperatures best suited to your specific design. As a starting point, we recommend the following conditions:

	<u>Casting Temperature</u>	<u>Flask Temperature</u>
Large Items	950°C / 1742°F	480°C / 900°F
Medium sized items	980°C / 1796°F	540°C / 1000°F
Small, intricate items	1020°C / 1868°F	590°C / 1100°F

4. **Cooling:** After casting, let the flask cool at room temperature until it is no longer red (approximately 10 minutes), then quench in water.
5. **Recycling:** This product can be recycled 50% reused / 50% new grain, under strictly clean casting procedures to avoid carryover of contaminants (investment material, etc.).
6. **Physical Properties:**

Ultimate Tensile Strength (UTS): 100,000 psi
As-Cast Hardness (Vickers): 225 Hv

We are always interested in hearing your opinion of how our products have performed for your application. Also, contact us should you have any questions, comments or require information regarding Imperial's wide range of gold, silver and platinum products.

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