

Fiche technique

99900067 - Bronze en grenailles BR10S pour la fonte

GENERAL INFORMATION

General information		Commercial composition (%)	
Typology	Bronze	CU	90.00
Color	Red	SN	10.00
Color shade	Pink		
Production process	Casting		
Grain refinement level	Low		
Deoxidation level	Low		

Melting Temperatures

Solidus [°C]	935.0
Liquidus [°C]	1000.0
Melting range [°C]	65.0

FULL CHARACTERIZATION DATA

Color coordinates

L *	a*	b*	c*	Yellow Index
85.8	6.2	17.8	18.8	

Mechanical characteristics

As cast hardness [HV 0.2]	110.0
Hardness after 70% area red. [HV 0.2]	280.0
Hardness after annealing [HV 0.2]	120.0
Tensile strength (Rm) [Mpa]	455.0
Yield strength (Rp0.2) [MPa]	206.0
Elongation at rupture (A) [%]	45.0

Physical characteristics

Density [g/cm ³]	8.7
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Product applications

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

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CASTING PROCESSING PARAMETERS

Pre-melting temperature

Temperature [°C]

POURING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1100	1130
0.5 - 1.2 mm	580	650	1080	1100
> 1.2 mm	460	600	1060	1080

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.