

TECHNICAL DATASHEET AND GUIDELINE

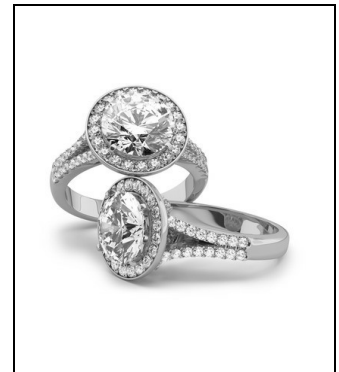
**AG115MA**  
Title 925 ‰

Ready-to-use 925‰ silver alloy for casting in drops

## GENERAL INFORMATION

Typology	Ready-to-use silver
Production process	Casting
Color	Silver
Color shade	--
Density [g/cm <sup>3</sup> ]	10.26
<b>Melting temperatures</b>	
Solidus [°C]	850
Liquidus [°C]	895

<b>Commercial composition</b>	
Ag (%)	93
Cu (%)	4
Zn (%)	3



## FULL CHARACTERIZATION DATA

<b>General characteristics</b>	
As cast grain size [µm]	270
Fluidity (grid filling test) [%]	100
<b>Color coordinates</b>	
L*	95.3
a*	-0.3
b*	4.7
c*	4.7
Yellow index	9.54

<b>Mechanical characteristics</b>	
Tensile strength (Rm) [MPa]	255
Yield strength (Rp0.2) [MPa]	100
Elongation at rupture (A) [%]	33
As cast hardness [HV 0.2]	55
Hardness after 70% area red. [HV 0.2]	166
Hardness after annealing [HV 0.2]	59
Single step age-hardening hardness [HV 0.2]	134

## PRODUCT APPLICATIONS

- Casting in closed systems
- Casting without stones
- 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)	990	1020	560	600
Medium (from 0.5 to 1.2 mm)	970	990	520	560
Thick (above 1.2 mm)	950	970	480	520

### Stone-in-place casting trees

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

### Trees without stones

Let the flask cool down in the chamber for 1 minute after pouring. Take the flask out of the machine without shaking it, let it cool for 15 minutes in air, then quench it in water.

## AGE HARDENING PROCESSING PARAMETERS

Age-hardening using solubilization treatment	Temperature [°C]	Time [min]	Quenching
Solubilization	750	40	Water, immediate
Age-hardening	300	60	Air or in furnace

Single step age-hardening treatment	Temperature [°C]	Time [min]	Quenching
Age-hardening	300	60	Air or in furnace