

PRODUCT CODE	BR 850 R
TYPE	SPECIAL BRASS
COLOR	PINK YELLOW



Brief description

Special brass for casting. Thanks to the high quantity of deoxidizing elements, this alloy helps to reduce the surface oxidation. BR 850 R is especially suggested in case of stones setting, and to produce thin patterns.
BR 850 R is nickel-free.

Suitable applications

Plates&Sheets	Solid Chains	Hollow Chains	Soldered Tubes	CNC Works	Open Casting	Closed Casting	Wax Setting
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Proprieties

Composition	Cu92 Zn4	Commercial composition of the alloy
Density	8.6	(g/cm ³)
Melting Range	880-985	Solidus - Liquidus (°C)
Hardness	125-N.A.	Annealed - Hardened (HV)

Casting

Cylinders' temperature should be 500-700°C, based on casted items' size and models' intricacy. Casting temperature is 50-120°C higher than the liquidus temperature. After casting wait 15-20 min before cooling the metal in warm water (≈40°C), in case of wax setting of stones, wait from 30 to 45 minutes before cooling the flasks in warm water.

Annealing

Heat the metal in protective atmosphere at 650°C for 15-20 min, then quickly cool it in a solution of 90% water and 10% alcohol or in warm water (≈40°C).

Hardening

Not suitable.

Pickling

Sulfuric acid (H₂SO₄) at 15-30% concentration and 50-60°C can be used to remove surface oxide. Rinse with attention the metal after pickling.

Scraps reuse

Up to 50% scraps can be added to the melting, removal of the sprue button is suggested. Always pay attention to the cleanliness of the scraps, pickling before adding them to new metal is suggested.