



Argenco 10S

“The most economical yellow casting alloy”

Composition

Au	Pd	Ag	Ir	Zn	In
10.0%	24.0%	45.9%	<1.0%	2.0%	18.0%

Technical Data

Type	Melting Range °C	Modulus of Elasticity MPa	Density gm/cc
III	920-970	85,000	10.7

Vickers Hardness DPN		Yield Stress MPa (0.2% offset)		Elongation %	
S	H	S	H	S	H
175	-	332	-	8	-

Solders

Pre-solder	Argesol Lo
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Laser Wire

Laser Wire	LWL 075
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Skillbond

*Note the colour of this card in no way represents the colour of the alloy.



Argenco 10S

Argenco 10S is a type III alloy of low gold content and offers a subtle pale yellow colour. Despite a gold content of only 10%, this alloy still offers a good tarnish and corrosion resistance. Argenco 10S does not contain any copper, nor any noxious metals and exhibits excellent biocompatibility.

Instructions for use:

Spruing	Single:	Use direct spruing with adequate reservoirs. Use 2.5 mm to 3.5 mm diameter sprues, 10 – 15 mm in length.
	Multiple:	Use indirect spruing with 4.0 mm diameter reservoir bars. Use 2.5 mm diameter sprues from the crowns to the reservoir bar and 3.5 mm diameter sprues from the reservoir bar to the sprue former cone.
Investment:		A high quality gypsum-bonded investment is required. Phosphate-bonded investments may be used. Follow the manufacturer's instructions.
Burnout:		After adequate bench setting, place the invested ring into a room temperature furnace and raise the temperature to 650°C and heatsoak for 30 minutes minimum.
Melting:		It is recommended to use a quartz crucible using a gas/air torch with a multi-orifice tip. Use a neutral or slightly reducing flame so as not to oxidise the alloy. If using an induction casting machine set the temperature to 1070°C and melt in a graphite-lined crucible. The alloy melts readily, so avoid overheating the alloy. Do not use flux. After casting, allow the ring to bench cool before devesting. Add 35% new alloy to the clean buttons.
Pickling:		Do not use any pickling solution. Microblast only.
Finishing:		Lightly grind the alloy with aluminum oxide stones, sintered diamonds or carbide burs. After grinding, use rubber wheels or bristle brushes with polishing paste.
Polishing:		Polish to a high lustre using impregnated polishing wheels or a woollen mop with polishing paste. Finally clean in a recommended solution in an ultrasonic cleaner for 5 minutes.