

# BLAZE

## NOBLE YELLOW TYPE 3 CROWN & BRIDGE ALLOY

PROPERTIES	
Melting Range	1625 to 2040°F (885° to 1115°C)
Density	10.3 g/cm <sup>3</sup>
Hardness	175 HV
Tensile Elongation	6%
Tensile Yield Strength	40,320 psi (278 MPa)
Ultimate Tensile Strength	58,015 psi (400 MPa)

CHEMISTRY	
Gold	5%
Palladium	32%
Silver	32%
Indium	30%
Zinc	1%
Au & Pt group - 37%	
Classification - Noble	

### PROCESSING TECHNIQUE

<b>INVESTMENT</b>	Phosphate-bonded high heat investment with or without carbon.
<b>BURNOUT</b>	1200°F (650°C)
<b>MELTING AND CASTING</b>	One extra turn of the casting arm recommended (3 turns). Multi-orifice torch: 5 psi fuel and 10 psi oxygen. Melt with a reducing flame using gas and compressed air or gas and oxygen with 5 PSI gas and 10 PSI oxygen. DO NOT HEAT TO POINT OF ALLOY FORMING A BALL. Cast as soon as a consolidated pool is formed. DO NOT USE CASTING FLUX. Add 50% new metal to buttons. Casting temperature is 2130°F (1165°C).
<b>SOLDER AND FLUX</b>	Solder: 615 Fine Solder Flux: Brown Fluoride Flux (for both pre & post soldering)

5243Y r2

