

Norm: UNI EN 1676 e 1706

Numeric designation: EN AB and AC - 21000

Symbolic designation: EN AB and AC - AlCu4MgTi

CHEMICAL COMPOSITION %

ALLOY DESIGNATION		ELEMENTS												
		Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Pb	Sn	Ti	Other each	Other total
EN AB 21000 EN 1676:2020	Min	0	0	4,2	0	0,20	0	0	0	0	0	0,15	0	0
	Max	0,15	0,30	5,0	0,10	0,35	0,03	0,05	0,10	0,05	0,05	0,25	0,03	0,10
EN AC 21000 EN 1706:2020	Min	0	0	4,2	0	0,15	0	0	0	0	0	0,15	0	0
	Max	0,20	0,35	5,0	0,10	0,35	0,03	0,05	0,10	0,05	0,05	0,30	0,03	0,10

NOTE: "Other each" includes the limits of all elements unspecified in the grid.

MECHANICAL PROPERTIES

(Mechanical properties obtained from samples cast separately at +20°C room temperature)

CASTING PROCESS (condition)	TEMPER DESIGNATION	Rm	Rp02	A	HB	R Fatigue*
		Tensile strength	Yield strength	Elongation	Brinell hardness	Fatigue resistance
		EN 1706:2020	EN 1706:2020	EN 1706:2020	EN 1706:2020	EN 1706:2020
		MPa	MPa	%	HBW	MPa
SAND	T4	300	200	5	90	80 - 110
PERMANENT MOULD	T4	320	200	8	90	80 - 110
INVESTMENT	T4	300	220	5	90	80 - 110

*Values for tests under rotating bending conditions up to 10⁷ cycles (Wöhler curve)

PHYSICAL PROPERTIES

(The following properties are spoilt by the variation of the chemical composition, by its metallurgic structure, casting integrity and casting conditions, therefore these values are approximate)

SPECIFIC WEIGHT	2,79 Kg/dm ³	ELECTRICAL CONDUCTIVITY	EN 1706:2020	16 - 23 MS/m
SPECIFIC HEAT (at 100 °C)	0,91 J/gK	THERMAL CONDUCTIVITY	EN 1706:2020	120 - 150 W/(m K)
ELASTIC MODULUS	72 GPa	LINEAR THERMAL EXPANSION (20 °C - 100 °C)	EN 1706:2020	23·10 ⁻⁶ /K

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TECHNOLOGICAL FEATURES

(Quality indications excerpted from the norm EN 1706:2020)

CASTABILITY	C	DECORATIVE ANODIZING	C
RESISTANCE TO HOT TEARING	D	ABILITY TO BE WELDED	D
PRESSURE TIGHTNESS	D	ABILITY TO BE POLISHED	B
MACHINABILITY (after cast)	-	STRENGTH AT ROOM TEMPERATURE	A
MACHINABILITY (after heat treatment)	A	STRENGTH AT ELEVATED TEMPERATURE (200°C)	B
RESISTANCE TO CORROSION	D	DUCTILITY	A

A: EXCELLENT, **B:** GOOD, **C:** FAIR, **D:** POOR, **E:** NOT RECOMMENDED, **F:** UNSUITABLE

GUIDELINES FOR USE

The ingot re-melting process must be carried out as fast as possible and overheating must be avoided (maximum melting temperature 750°C). Iron tools that may be touched by the liquid metal must be specially painted to avoid spoiling the alloy. The best alloy purification results are achieved by treating the alloy with inert gases, such as nitrogen and/or argon, to remove dissolved hydrogen and any oxides in the liquid bath. A careful skimming of the bath is recommended. It is allowed to recycle sprues and casting appendages up to 40% out of the total charge weight.

Heat Treatment - The possible treatments and the properties to be potentially achieved are listed in the table "MECHANICAL PROPERTIES".

FURTHER FEATURES OF THE ALLOY

Resistance to weathering and seawater - Limited resistance to weathering and corrosion in general; it is not suitable for applications directly touched by seawater.

USUAL APPLICATIONS

This alloy is suitable for highly stressed castings, which do not need a particular corrosion resistance, such as aircraft and transport construction; high-voltage switchgear; textile machinery; armament industry.
This alloy **does not comply** with Standard **EN 601**.

DISCLAIMER

Contents are for information purposes only, they do not assure the mentioned properties. The user is held responsible for decisions based on such information and they are not exonerated from verification. Should this not be carried out, Raffmetal S.p.A. assumes no liability.