

Norm: UNI EN 1676 e 1706

**Numeric designation:** EN AB and AC - 44000

**Symbolic designation:** EN AB and AC - AISi11

## CHEMICAL COMPOSITION %

ALLOY DESIGNATION		ELEMENTS												
		Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Pb	Sn	Ti	Other each	Other total
EN AB 44000 EN 1676:2020	Min	10,0	0	0	0	0	0	0	0	0	0	0	0	0
	Max	11,8	0,15	0,03	0,10	0,45	0,03	0,03	0,07	0,03	0,03	0,15	0,03	0,10
EN AC 44000 EN 1706:2020	Min	10,0	0	0	0	0	0	0	0	0	0	0	0	0
	Max	11,8	0,19	0,05	0,10	0,45	0,03	0,03	0,07	0,03	0,03	0,15	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	F	150	70	6	45	60 - 90
PERMANENT MOULD	F	170	80	7	45	60 - 90

\*Values for tests under rotating bending conditions up to 10<sup>7</sup> 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 <sup>3</sup>	ELECTRICAL CONDUCTIVITY	EN 1706:2020	18 - 24 MS/m
SPECIFIC HEAT (at 100 °C)	0,91 J/gK	THERMAL CONDUCTIVITY	EN 1706:2020	140 - 170 W/(m K)
ELASTIC MODULUS	72 GPa	LINEAR THERMAL EXPANSION (20 °C - 100 °C)	EN 1706:2020	21·10 <sup>-6</sup> /K

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### TECHNOLOGICAL FEATURES

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

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

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

\*If Mg > 0,1%, it switches into B.

### GUIDELINES FOR USE

The ingot re-melting process must be carried out as fast as possible and overheating must be avoided (maximum melting temperature 780°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** - Alloy not to be treated.

### FURTHER FEATURES OF THE ALLOY

**Resistance to weathering and seawater** - Limited resistance to weathering; not suitable for applications directly touched by seawater.

**Notes** - Castability is excellent and makes it possible to use it a lot. The higher the content of Mg is, the more this alloy tends to hot tearing, even if this tendency is not well-defined. A refining treatment with TiB refiners is recommended to achieve compact components, while a modification treatment with Sodium (Na) or Strontium (Sr) is necessary to increase deformability.

### USUAL APPLICATIONS

This alloy is suitable for complex castings, thanks to its good pressure tightness and weldability. It is used in the automotive, engine, railway, aeronautics and armory industries.

This alloy **complies (for information)** with Standard **EN 601**.

### DISCLAIMER

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