

TECHINICAL DATASHEET

			COPPER MOULD		
			Mouldmetal-1 Sf Cu Din 1787	Mouldmetal-2 CuAg0.1	Mouldmetal-3 CuCrZr
ITEM	TEMPERATURE	UNIT			
Chemical Composition					
		%	P 0.015-0.040 Balance	Ag 0.08-0.12 0.004-0.012 Balance	P Cu: 0.30-1.20 0.03-0.30 Balance
Physical Properties					
Electrical Conductivity	20	%IACS	83	95	80
Thermal Conductivity	20	W/(m*k)	340	372	330
Coefficient of Thermal Expansion	20-300	10 ⁻⁶ /K	17.1	17.1	17.2
Recrystallisation Temperature		°C	345	360	690
Modulus of Elasticity	20	10 ³ Mpa	120	123	126
Melting Point		°C	1083	1083	1078
Specific Gravity		g/cm ³	8.9	8.9	8.9
Mechanical Properties					
Shore Hardness Min.	20	Mpa	240-310	240-310	375-445
Shore Hardness Min.	20	Mpa	190-250	200-225	280-355
Shore Hardness Min.	20	%	25-ott	16-ott	20-13
Porosity Max.	20	HB	80-95	110-125	115-130



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COPPER MOULD TUBE

NAME	SHAPE/SIZE	RADIUS	THICKNESS	LENGTH	REMARKS (Unit: mm)
Square & Rectangular Mould	Square 50x50≈650x650 Rectangular (100≈500)x650	3000-17000 & Straight	6≈50	602-1100	Design with single taper, double tapers, triple tapers, quadruple tapers, parabolic taper, double parabolli tapers
Round Mould	ø110≈ø1500	6000-17000 & Straight	10≈50	602-900	Design with double tapers, triple tapers, multi-taper, continuous tapers
Beam Blank Mould	As per order	6000-14000	12≈50	700-1016	triple tapers, multi-taper, continuous tapers

COPPER MOULD PLATE

SIZE	LENGTH	WIDTH	THICKNESS	MATERIAL	COATING
Slab Mould	350-3800	700-1000	30-75	Cr-Zr-Cu, CuAg	Ni-Co, Cr, Ni-Fe
Beam Blank Mould	350-900	300-1000	35-300	Cr-Zr-Cu, CuAg	Ni-Co, Cr, Ni-Fe
Rectangular Mould	700-900	200-3000	30-70	Cr-Zr-Cu, CuAg	Ni-Co, Cr, Ni-Fe

Coating Parameters

SPECIFICATION	UNIT	MATERIAL OF COATING			
		Cr	Ni	Cr-Fe	Ni-Co
Hardness	HV	600 min.	140 min.	250 min.	300 min.
Thermal Conductivity	W/(m*k)	60≈66	76≈84	63≈88	75≈84
Adhesive Strength	N/mm ²	240 min.	220 min.	220 min.	240 min.
Thickness	mm	-----	0≈3	0≈3	0≈3



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