

Characteristics

WB 30 PM - T is a very light earthenware body for casting.
Available as blended powder (WB 30 PM - T), plastic body (K 140) and casting slip in buckets (K 150).

Firing Colour	white
Recommended Firing Temperature Range	1000 - 1150 °C

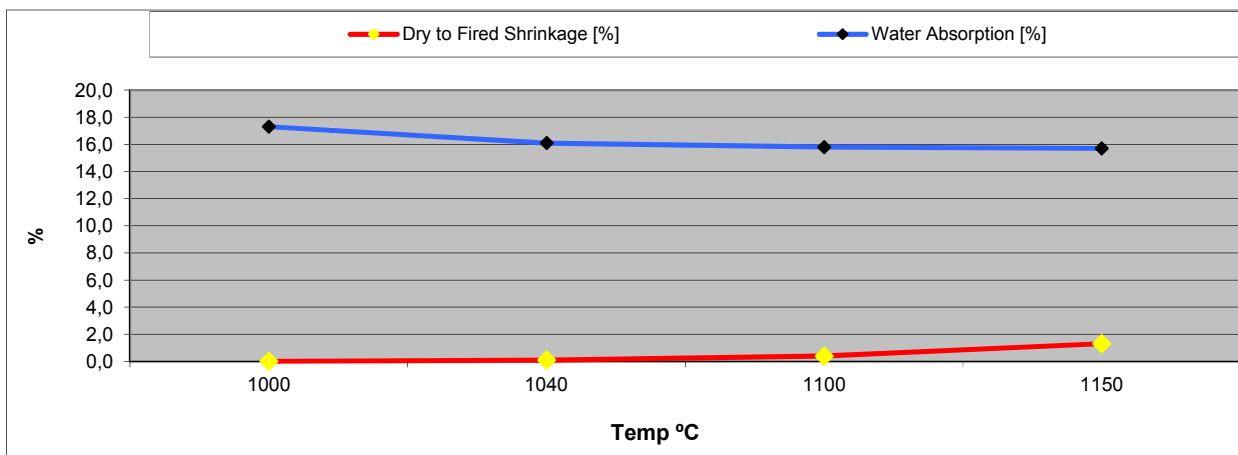
Technical Data

Unfired

Moisture	0,8% powder							
Chemical Analysis	SiO ₂	TiO ₂	Al ₂ O ₃	Fe ₂ O ₃	CaO	MgO	K ₂ O	Na ₂ O
	73,9%	0,70%	17,3%	0,60%	6,00%	0,20%	1,20%	0,20%
Loss of Ignition	10,0%							
Wet to Dry Shrinkage	3,2% casting							

Fired

Specimen Firing Temperature [°C]	1040
Coefficient of Thermal Expansion [x10 ⁻⁶ /°C]	
20 - 400 °C	7,5
20 - 500 °C	8,0
20 - 600 °C	10,0
Dry to Fired Shrinkage [%]	0,3
Water Absorption [%]	16,0



Dolaflux B 11 : Giessfix 162	1 : 2
Optimum Amounts	0,15% - 0,19%

First deflocculant and afterwards, add the powder under slow stirring to the water.

Specific Weight to Achieve	1820 - 1840 g / l
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WB 30 PM - T needs about 37l water per 100 kg powder to achieve s.w. of 1840 g / l

Test the casting advice in own production first remembering the mentioned amounts are depending on the hardness of the water, the type of blunger, and the desired properties of the casting.

- use the right amount of deflocculant to achieve optimum casting time
- if castthickness is too small, use less deflocculant
- don't use more than 10 - 15 % of scrap (above the fresh made slip)

The technical data quoted on this sheet is indicative only. Any sale is by sample and is governed by our general conditions of sale.



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