



RAFFMETAL

THE ALUMINIUM EVOLUTION



Leghe di alluminio in colata continua. Continuous casting aluminium alloys

Standard: **UNI EN 1676 and 1706**

Alloy group: **Al Si 9 Cu**

Alloy designation: **EN AB and AC 46500 - Al Si 9 Cu 3 (Fe)(Zn)**

Replaces: **LM 24**

CHEMICAL COMPOSITION %

ALLOY		ELEMENTS												
		Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Pb	Sn	Ti	Individual impurities	Global impurities
EN AB 46500	min	8,0	0,60	2,00		0,15								
	max	11,0	1,20	4,00	0,55	0,55	0,15	0,55	3,00	0,35	0,25	0,20	0,05	0,25
LM 24	min	7,5		3,00										
	max	9,5	1,3	4,00	0,55	0,30	0,15	0,55	3,00	0,35	0,25	0,20	0,05	0,25

MECHANICAL FEATURES DETECTED FROM SEPARATE CASTING TEST SPECIMENS

Casting process	Temper designations	Rm Tensile strenght		Sp 0,2 Yield strenght		A Elongation		HB Brinell hardness	
		EN 1706	BS 1490:88	EN 1706	BS 1490:88	EN 1706	BS 1490:88	EN 1706	BS 1490:88
		Mpa	N/mm2	Mpa	N/mm2	%	%	HBW	HB
SAND (as cast)	-	-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-
SHELL (as cast)		-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-
PRESSURE DIE (as cast)	F	240	180 - 320	140	100 - 150	1	1 - 3	80	80 - 100

PHYSICAL PROPERTIES (indicative values subject to the UNI EN and ex BS 1490:88 Standards)

DENSITY	2.79 Kg/dm ³	THERMAL CONDUCTIVITY at 20°C	110 - 120 W/(m K)
MELTING RANGE or MELTING POINT	520 °C 580 °C	LINEAR THERMAL EXPANSION from 20 t 100°C	-
SPECIFIC HEAT (at 100)°		LINEAR THERMAL EXPANSION from 20 t 200°C	21.0-10-6/°C
LINEAR SHRINKAGE IN SAND PROCESS		LINEAR THERMAL EXPANSION from 20 t 300°C	-
LINEAR SHRINKAGE IN SHELL PROCESS		SUGGESTED MAXIMUM TEMPERATURE	750 °C
LINEAR SHRINKAGE IN HIGH PRESSURE	0,013	SUGGESTED CASTING TEMPERATURE	
ELECTRIC CONDUCTIVITY	13 - 17 MS/m	°in sand	
MODULUS OF ELASTICITY	7200 Kg/mm ²	°in shell	
		°in pressure die	640 - 710 °C

TECHNOLOGICAL FEATURES, QUALITATIVE INDICATIONS

STRENGTH AT ELEVATED TEMPERATURE (to 200°C)	EXCELLENT	RESISTANCE TO HOT TEARING	SMALL
GENERAL RESISTANCE TO CORROSION	LOW	PRESSURE TIGHTNESS	GOOD
MACHINABILITY	GOOD	WELDABILITY	LOW
CASTABILITY	GOOD	DECORATIVE ANODISING	LOW
POLISHING	MEDIUM	PROTECTIVE ANODISING	

AZIENDA CON SISTEMA DI GESTIONE PER LA QUALITÀ CERTIFICATO DA DNV = UNI EN ISO 9001:2008 =

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AZIENDA CON SISTEMA DI GESTIONE AMBIENTALE CERTIFICATO DA DNV = UNI EN ISO 14001:2004 =



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GENERALITIES REGARDING USE

The ingot recasting process must be carried out as quickly as possible and overheating must be avoided (maximum melting temperature 750°C).

The iron tools that can come into contact with the liquid metal must be appropriately painted to prevent contamination of the alloy.

The best results for refining the alloy are reached by treatments with inert gases such as nitrogen and/or argon with the intent of removing the hydrogen dissolved and the oxides present in the bath of molten metal. Better distribution of the gas in the molten metal is obtained by the use of relevant rotors. Pay particular attention that all transfer operations of the molten metal are performed with less turbulence possible. It is recommended to leave the molten metal at rest for a few minutes before starting casting. Careful skimming operations of the bath are recommended.

The re-cycling of risers and casting appendixes is allowed but within the limits of 40% of the total weight of the load.

The EN 46500 alloy is delivered by RAFFMETAL exclusively under the form of ingots produced with Continuous Casting, this has the following advantages:

- Lower presence of oxides with consequent reduced aptitude for the formation of HARD POINTS
- Fine and even structure with reduced quantity and dimension intermetallic compounds
- Reduced hydrogen content in relation to the high solidification speed.
- Possibility of customising according to different options of the dimensions and geometry of the stack
- Less risk of explosion of the ingot in the melting phase owing to the smaller presence of open shrinkage cavities.
- Improved metal yield owing to the excellent surface quality of the ingot

SPECIFICITY REGARDING USE

The EN 46500 alloy, more commonly known as A 380, is among the great "worldwide" classics of pressurised casting aluminium alloys. It is relatively easy to use and therefore requires general attention that characterise the foundry aluminium alloys.

TYPICAL USE

Alloy generally used in pressurised casting with good mechanical features. It is used in engineering applications and the building sector.

Alloy **not in compliance with the EN 601** foodstuff Standard

COMPARISON WITH EQUIVALENT OR SIMILAR FOREIGN STANDARDS

	ITALY	GERMANY	FRANCE	G.B.R.	USA	ISO	JAPAN	TURKEY
	UNI	(Din1725/5-86)	(NFA57-105)	(BS1490-88)	(ASTM B179-82)	(3522-84)	(JIS H2211-92)	(ETIAL)
Equivalent	-		A S9U3Z	LM 24	A380.1	-	ADC10Z	-
Similar		DIN 226			A333.1	ALS18CU3FE	AC4B.1	ETIAL-160

HEAT TREATMENTS

Heat treatments are not normally provided.

Limitation of liability

The contents of these technical sheets gave an informative purpose and do not constitute a warranty regarding the properties stated. The decisions based on this information are taken under the responsibility and risk of the user and do not exclude it from the verification. If the former are not carried out, we do not assume any liability.

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