

# GIALLOY PA / PA-F



Dental

Non – precious dental alloys

CE 0297

Partial framework alloy on Cobalt basis

- Gialloys can be melted by torch, centrifuge and vacuum pressure systems
- Gialloys are highly corrosion resistant
- Gialloys can be lasered

## Casting

Use ceramic crucibles only.  
Cast as fast as possible before oxide layer is torn open. Do not force cool or quench the moulds.  
Cool down slowly after casting.

## Processing instructions

### Modelation

For 100 % flow out of wax copies, minimum wax thickness should be 0.5 mm.

### Duplicating

For master model duplication Gildouble S is recommended.

### Investing

Gialloys can be casted with most of the investments usual in trade up to max. casting temperature of 1080°C (1980°F).  
Recommended investments for partials out of Gialloy PA and Gialloy PA-F are Gilvest MG Speed or Gilvest MG Vario.

## Caution

Never put Gialloys in acid bath.

All data and recommendations are guidelines only and based on our technical experience. The above recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside our control

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## Typical chemical compositions and physical properties of Gialloy

	<b>Gialloy PA</b> Partial framework alloy on Cobalt basis Type 5 Nickel and Beryllium free	<b>Gialloy PA-F</b> Partial framework alloy on Cobalt basis Type 5 Nickel and Beryllium free
Norm	EN ISO 22674	EN ISO 22674
Co	62	62,5
C	0,6	0,5
Cr	30	29
Ni	-	-
Si	1	0,4
Mo	5,5	6
W	-	1
Mn	0,6	0,6
Hardness: (HV 10)	< 400	410
Elongation: (%)	> 6	> 6
Tensile strength: (MPa)	700	900
0,2% Elastic limit: (MPa)	620	620
Modulus of elasticity (GPa)	230	230
Melting range (°C) (Solidus/Liquidus)	1250 – 1260	1340 – 1370
Pre-heating temp. of ring (°C)	930 – 950	930 - 950
Density (g/cm <sup>3</sup> )	8,3	8,3