

Characteristics

WB 30 PM is a very light earthenware body for casting.

Available as blended powder (PB WB 30PM PO), plastic body (PB K 140 BO)

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

Technical Data (typical values)

Unfired

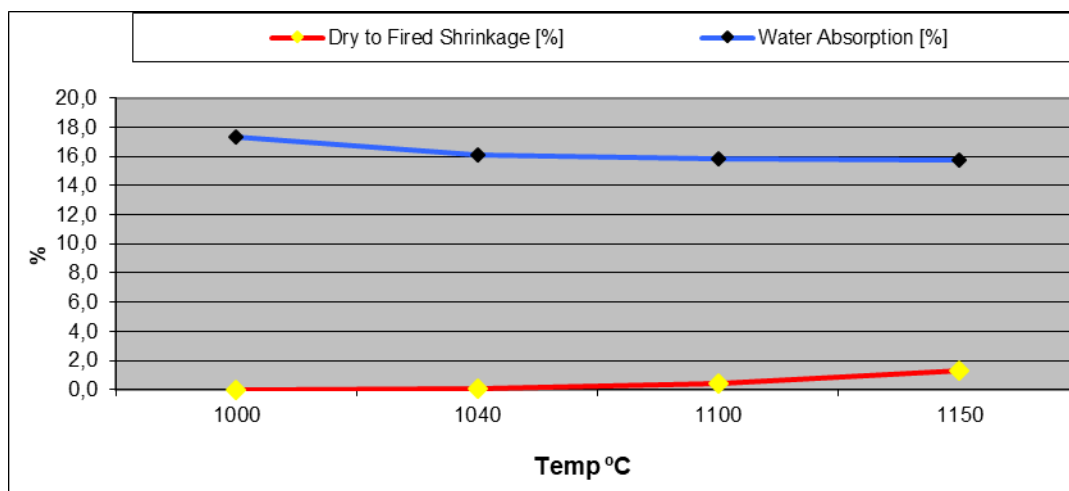
Moisture	0,8%	powder						
Chemical Analysis	SiO ₂	TiO ₂	Al ₂ O ₃	Fe ₂ O ₃	CaO	MgO	K ₂ O	Na ₂ O
	73,9%	0,70%	17,3%	0,60%	6,00%	0,20%	1,20%	0,20%
Loss of Ignition				10,0%				

Particle size Distribution [µm]
 Undersize [%]

Wet to Dry Shrinkage	3,2%	casting
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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



Casting Advice

Dolaflux B 11 : Giessfix 162

Optimum Amounts

1 : 2
0,15% max. 0,19%

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

Specific Weight to Achieve

1820 - 1840 g / l

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)



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