

## Characteristics

WM is a stoneware body. It is suitable for plastic forming methods.

Available as blended powder ( PB WM PO ) and plastic body ( PB WM BO ).

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Firing Colour	white - cream - grey
Recommended Firing Temperature Range	1000      -      1300 °C

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### Technical Data (typical values)

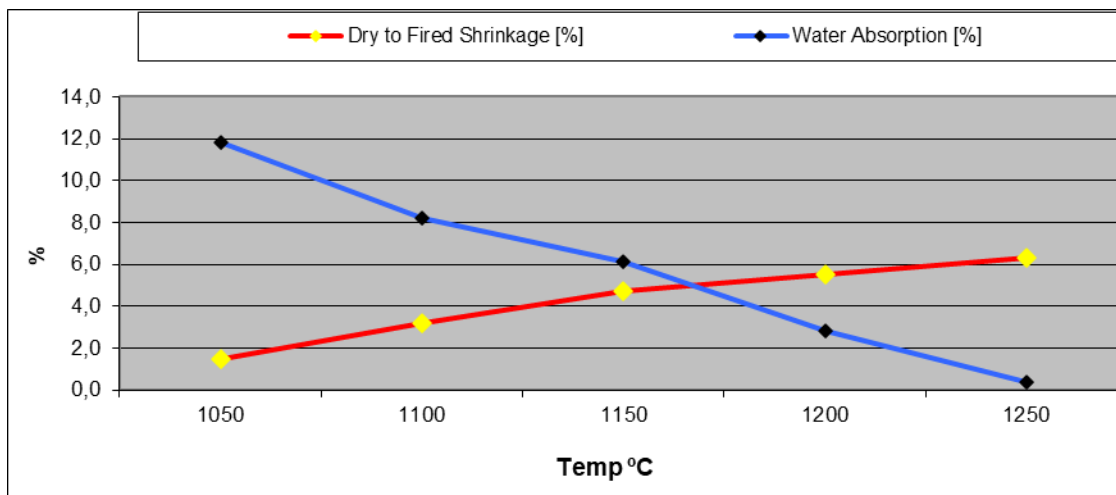
#### Unfired

Moisture					20,0%	plastic			
Chemical Analysis	SiO2	TiO2	Al2O3	Fe2O3	CaO	MgO	K2O	Na2O	
	75,2%	1,50%	19,4%	0,80%	0,20%	0,40%	2,30%	0,20%	
Loss of Ignition					5,8%				

Wet to Dry Shrinkage	5,8%	plastic properties
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#### Fired

Specimen Firing Temperature [°C]	1200
Coefficient of Thermal Expansion [x10 <sup>-6</sup> /°C]	
20 - 400 °C	6,9
20 - 500 °C	7,5
20 - 600 °C	8,9
Dry to Fired Shrinkage [%]	5,5
Water Absorption [%]	2,8



### Casting Advice

Dolaflux B 11 : Giessfix 162

Optimum Amounts

1 : 2  
0,29% - 0,33%

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

Specific Weight to Achieve

1790 - 1810 g / l

WM - T needs about 41 l water per 100 kg powder to achieve s.w. of 1800 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 )

## For Product Information & Customer Service

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