

Premium 2.0 Nuggets™ Annealing Guidelines: 1/2" - 8" (12mm - 203mm)

Annealing & Cooling

	Step 1		Step 2		Step 3		Step 4	
Target Temps	920° F 493° C		775° F 413° C		600° F 316° C		100° F 38° C	
Maximum Thickness	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)
1/2" 12 mm	None	120	100° F 55° C	10	200° F 111° C	10	250° F 139° C	0
3/4" 19 mm	None	180	50° F 28° C	10	100° F 55° C	10	200° F 111° C	0
1" 25 mm	None	240	25° F 14° C	10	45° F 25° C	10	150° F 83° C	0
1.5" 38 mm	None	360	12° F 6.7° C	45	24° F 13° C	10	75° F 42° C	0
2" 51 mm	None	480	7° F 3.9° C	60	14° F 7.8° C	10	42° F 23° C	0
3" 76 mm	None	720	3° F 1.7° C	120	5.4° F 3.1° C	30	18° F 10° C	0
4" 102 mm	None	960	1.5° F 0.8° C	300	3° F 1.7° C	45	9° F 5° C	0
5" 127 mm	None	1200	1.2° F 0.7° C	375	2.4° F 1.3° C	60	7.2° F 4° C	0
6" 152 mm	None	1440	0.8° F 0.4° C	450	1.3° F 0.76° C	150	4.5° F 2.5° C	0
7" 178 mm	None	1680	0.6° F 0.3° C	525	1.0° F 0.58° C	225	3.4° F 1.9° C	0
8" 203 mm	None	1920	0.4° F 0.2° C	600	0.76° F 0.42° C	300	2.4° F 1.3° C	0

Technical Data

Strain Point	850°F
	454°C
Anneal Point	917°F
	492°C
Softening Point	1235°F
	668°C

