

UNITED "YELLOW" ALLOY # 98

Thank you for using UNITED'S alloys.

UNITED # 98 ALLOYS may be used for **10 K & 14 K castings**.

You should obtain excellent results by following a few simple instructions.

MELTING

We do recommend pre-alloying all alloy and fine gold with aggressive stirring & fluxing to assure a uniform mixture.

Step : 1	Pre- Alloying (Fine gold + alloy) Temperature	1010° - 1040° C 1850° - 1910° F
Step : 2	Casting Temperature for 10 K Alloyed Grain	970° - 990° C 1780° - 1815° F
	Casting Temperature for 14 K Alloyed Grain	950° - 970° C 1745° - 1780° F

NOTE: Melt temperature may vary with type of unit. This alloy is designed for casting only.

FLASK TEMPERATURE

Normal recommended temperature in the range of **580° C to 700° C / 1076° F – 1292° F** depending on size of flask, karat & type of jewelry.

FLUXING

Boric Acid is the recommended flux. Use as little flux as possible. Do not use carbon fluxes or any fluxes designed for refining; i.e., soda ash, saltpeter, etc. Avoid flux in bottom pour automatic casting units.

QUENCH TIME

20 – 25 minutes.

INVESTMENT REMOVAL

Most standard investment removers will successfully remove the investment powder. Fluoric-based investment removers are the best for removing the silicon oxide invisible coating. Use of aggressive acids causes stress corrosion and surface damage and is therefore not recommended.

UNITED'S Brite-Cast™ Investment Remover works effectively in removing fire scale as well as preventing stress corrosion or surface damage of the cast piece.

REMELTING

We recommend a 35% - 50% fresh mix for re-melting, unless our # 99 Alloy Replenisher is used.

TECHNICAL ASSISTANCE

Always available... Call 1-800-999-3463 / 1-800-999-FINE
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