

UNITED “BRIGHT YELLOW” ALLOY # 383

Thank you for using UNITED’S alloys.

UNITED’S # 383 ALLOY is designed for **20 K – 22 K** bright yellow gold **casting (& fabrication)**, which produces a **Bright Yellow color**.

MELTING	Step : 1	We do recommend pre-alloying all alloy and fine gold with aggressive stirring & fluxing to assure a uniform mixture.	
		Pre- Alloying (Fine gold + alloy) Temperature	1100° - 1130° C 2012° - 2066° F
	Step : 2	Casting Temperature for Alloyed Grain	1080° - 1100° C 1976° - 2012° F
FLASK TEMPERATURE		For Vacuum casting	676° - 730° C 1250° - 1350° F
		For Centrifugal casting	537° - 565° C 1000° - 1050° F

NOTE: Melt temperature may vary with type of unit. This alloy is designed for Casting and Fabrication (Rolling, Wire, Tube, Sheet).

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 **15-20 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 50% rejuvenation for re-melting.

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