
**# 385 DARK YELLOW ALLOY FOR 20 K – 22 K YELLOW GOLD
CASTING & SHEET, PLATE, AND WIRE FABRICATION**

United # 385 dark yellow alloy is formulated for **20 K to 22 K** Dark Yellow Gold Casting and sheet, plate & wire fabrication giving a **Dark Yellow color**. The # 385 Dark Yellow Alloy **can also be used for Investment Casting if desired**.

MELTING	The # 385 Dark Yellow Alloy and fine gold should be melted together in a clean crucible. Put alloy in the bottom of the crucible and fine gold on top. Initial melting temperature should be 1100° - 1120° C / 2012° - 2048° F . Drop temperature somewhat before pouring as listed below. Boric acid flux may be used to keep the metal clean during the melting process. The metal should be mixed well with a stirring rod before pouring to assure a good mix.
POURING TEMP FOR INGOTS	20 K – 22 K - 1100° - 1110° C 2012° - 2030° F
POURING	Metal should be poured into a preheated, vertical graphite or lightly lubricated iron mold. A steady even pouring motion should be used slowing down at the end of the pour to prevent shrinkage in the top of the ingot. Use a round rod mold for wire and a 2 piece L shaped mold for plate and sheet.
QUENCHING	The metal ingot should be removed from the mold and quenched immediately in pickle solution or water. For heavy ingots a one-minute cool down before quenching prevents quench cracking.
FABRICATION	The metal ingot should be cleaned of all adhering oxide or fluxes before rolling. The ingot should be rolled or drawn to a 50% reduction in size before annealing. After annealing continue the reduction at 50% before annealing again. Clean the ingot after each anneal. Keep rolls, dies and metal clean to prevent defects in the finished stock.
ANNEALING	Annealing temperature 675° C / 1250° F for 20 minutes. Quench immediately in water or pickle solution . A boric acid fire coat should be applied before annealing in open atmosphere ovens to protect the metal from heavy oxidation. Avoid over-annealing wire or plate stock as this can cause excessive grain growth creating orange peel effect on the surface of finished goods.
REMELTING	Use a 50% scrap to fresh mix when re-melting to prevent oxide build up in the metal.
TECHNICAL ASSISTANCE	Always available... Call 1-800-999-3463 / 1-800-999-FINE E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

2781 Townline Road , Alden, NY 14004 .
Phone : (800) 999-3463; International Phone : +1-(716)-683-8334
Fax : (800) 533-6657; International Fax : +1-(716)-683-5433
e-mail: sales@unitedpmr.com; Website: www.unitedpmr.com