

UNITED “DEEP YELLOW” ALLOY # 397

Thank you for using UNITED’S alloys.

UNITED’S # 397 ALLOY is designed for **18 K – 22 K** yellow gold **casting**, which produces a **Deep Yellow color**, popular in the middle-east.

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) Temp 18 K	1070° - 1080° C 1958° - 1976° F
	Pre- Alloying (Fine gold + alloy) 20 K – 22 K	1100° - 1130° C 2012° - 2066° F
Step : 2	Casting Temperature for Alloyed Grain 18 K	1000° - 1010° C 1832° - 1850° F
	Casting Temperature for Alloyed Grain 20 K – 22 K	1080° - 1100° C 1976° - 2012° F

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

FLASK TEMPERATURE

For 18 K- use normal recommended temperature.
 For 20 K – 22 K Vacuum casting **676° - 730° C**
1250° - 1350° F
 For 20 K – 22 K Centrifugal casting **537° - 565° C**
1000° - 1050° F

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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