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**# 398 YELLOW ALLOY FOR 18 K – 22 K YELLOW GOLD SHEET, PLATE, AND WIRE FABRICATION**

United # 398 yellow alloy is formulated for **18 K to 22 K** Yellow Gold sheet, plate and wire fabrication giving a **Yellow color**. The # 398 Yellow Alloy **can also be used for Investment Casting if desired**.

**MELTING**

The # 398 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** for 20K-22K, and **1070° - 1080° C / 1958° - 1976° F** for 18K. 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**

18K - **1000° - 1010° C**  
**1832° - 1850° F**

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](mailto:doc@unitedpmr.com) Web-Site / [www.unitedpmr.com](http://www.unitedpmr.com)

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