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**# 548 ALLOY FOR 9 K – 18 K PINK GOLD**  
**CASTING, SHEET, PLATE & WIRE FABRICATION**

UNITED'S # 548 ALLOY is a **Pink** master alloy designed for **9 K to 18 K** pink gold **casting and rolling**, which produces a **pink finished color**. Alloy # 548 is much easier to cast, fabricate and set stones compared to other colors.

**KARATING**

The # 548 Pink Alloys and fine gold should be melted together in a clean crucible. Put the alloy in the bottom of the crucible and the fine gold on top. Initial melting temperature should be **1050° C – 1060° C / 1922° F - 1940° F**. Drop the temperature somewhat before pouring as listed below. Boric acid flux should be used to keep the metal clean during the melting process. The molten metal should be mixed well with a stirring rod before pouring to assure a good mix. A neutral or reducing cover gas is very helpful in melting pink gold alloys.

**POURING TEMP FOR INGOTS**

9 K – 18 K - **1015° C - 1030° C (Quench in water within 3 min for 18K)**  
**1860° F – 1886° 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**

Remove the ingot from the mold and quench. Pink Gold rolling alloys will be much softer if allowed to quench after pouring and after annealing. Soak ingot in a hot pickle solution to remove surface oxides.

**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. Too small of a reduction can cause ingot to crack during anneal. After annealing continue the reduction at 50% before annealing again. Clean the ingot after each anneal in hot pickle solution. Keep the rolls, dies, and metal clean to prevent defects in the finished stock. Limit original ingot thickness to 5 mm.

**ANNEALING**

Annealing temperature **704° C / 1300° F for 20 minutes. QUENCH INGOT in water, as soon as possible**. A boric acid fire coat should be applied before annealing in an open atmosphere oven to protect the metal from heavy oxidation. Clean the ingot in hot pickle solution to remove surface oxidation after annealing. Avoid over-annealing wire, plate or sheet stock as this can cause excessive grain growth creating orange peel surface or poor strength in finished goods.

**REMELTING**

Use a 30% scrap to 70% fresh mix for re-melting. Sprues & buttons need to be steel shot tumbled for at least 2 hrs to remove the oxide layer before re-melting.

**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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