

## UNITED "RICH YELLOW" ALLOY # 725

Thank you for using UNITED'S alloys.

UNITED'S # 725 ALLOY is designed for **18 K yellow gold casting & fabrication**, which produces a **Rich Yellow color**.

You should obtain excellent results by following a few simple instructions.

### 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) Temperature **1050° - 1070° C**  
**1922° - 1958° F**

**Step : 2** Casting Temperature for 18 K Alloyed Grain **1030° - 1040° C**  
**1886° - 1904° F**

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

### FLASK TEMPERATURE

We recommend a slightly higher flask temperature for 18 K.

### 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

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

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