

**UNITED “DEEP YELLOW  
(EUROPEAN 4N COLOR)” ALLOY # 790**

Thank you for using UNITED’S alloys.

UNITED’S # 790 ALLOY is designed for **18 K yellow gold casting & fabrication**, which produces a **Deep Yellow color(European 4N 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 **1000° C / 1832° 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**

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

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