

UNITED ALLOY # 862 (WHITE BRONZE)

Thank you for using UNITED'S alloys.

UNITED'S # 862 Casting White Bronze is a nickel based white bronze designed to cast jewelry samples, models, belt buckles, art objects, etc. It finishes to a Ultra White color and easily solders with silver or low white gold formulas # 862 also contains a silicon de-oxidizer for clean casting. White Bronze # 862 is also known as "Nickel or German Silver".

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

CASTING TEMPERATURE **1150° C - 1160° C**
2102° F – 2120° F

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting only. # 862 White Bronze may be Rhodium plated as normal. For # 862 Bronze, we recommend an ultrasonic cleaning solution called BCR available from OKITE, phone # 1-800-526-4473 ext. 2411.

FLASK TEMPERATURE We suggest a high flask temperature for light and medium weight pieces
1200° F- 1300° 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 **25 – 30 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 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.

TECHNICAL ASSISTANCE Always available... Call 1-800-999-3463 / 1-800-999-FINE
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