
UNITED “PREMIUM WHITE” CASTING GRAIN

18KWCG RM-1

“ZING WHITE”

Composition: 75.00 % Gold, 15.0% Nickel, 7.50 % Zinc, 2.50% Copper

UNITED’S # 18KWCGRM-1 grain comes as a ready-to-cast grain **18 K white gold casting**, which produces a **Super White finished color**.

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

MELTING

We do recommend aggressive stirring & fluxing to assure a uniform mixture prior to pouring it into the investment flask.

Step : 1 Casting Temperature for 18 K Alloyed Grain **1010°-1030° C**
1850°-1886° F

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting only.

FLASK TEMPERATURE

Normal recommended temperature in the range of **650° C to 700° C / 1200° F – 1300° F** depending on size of flask, karat & type of jewelry.

FLUXING

Boric Acid is the recommended flux. 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 – 25 minutes (Quench Button first in water).

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 a 70% fresh - 30% scrap mix. White gold alloy has about 1/3 the reusability of yellow gold alloys.

TECHNICAL ASSISTANCE

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