

UNITED “ULTRA WHITE” ALLOY # 952

Thank you for using UNITED’S alloys.

UNITED’S # 952 ALLOY may be used for **9 K – 14 K white gold casting**, which produces a **White finished color**. # 952 contains silicon, and boron deoxidizers. This alloy has been proven to **perform very well for Stone-In-Place castings**.

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° - 1060° C 1922° - 1940° F
Step : 2	Casting Temperature for 9 K – 10 K Alloyed Grain	1010° - 1020° C 1850° - 1868° F
	Casting Temperature for 14 K Alloyed Grain	1000° - 1010° C 1832° - 1850° 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 **580° C to 700° C / 1076° F – 1292° F** depending on size of flask, karat & type of jewelry.

FLUXING

Fluxing white gold is extremely important to pick-up oxides. 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

15 to 20 minutes after pouring.

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 50% fresh - 50% scrap mix.

TECHNICAL ASSISTANCE

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