
UNITED “PREMIUM WHITE” ALLOY # M-930

Thank you for using UNITED’S alloys.

UNITED’S # **M-930** ALLOY is a **higher fluidity version of our #930 alloy** may be used for **9 K – 18 K white gold casting**, which produces a **Premium White finished color**. # **M-930** contains a silicon and Boron deoxidizer.

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	1040° - 1050° C 1904° - 1922° F
Step : 2	Casting Temperature for 9 K – 10 K Alloyed Grain	1020° - 1030° C 1868° - 1886° F
	Casting Temperature for 14 K – 18 K Alloyed Grain	1000° - 1020° C 1832° - 1868° 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. Add about ½ teaspoon of Boric acid to the molten liquid metal and stir aggressively. Remove all the boric acid and impurities by skimming the same from the surface of the molten metal prior to pouring into shots or casting. Repeat this process a couple times if necessary.

QUENCH TIME

25 – 30 minutes depending on Flask Size & Styles of Jewelry.

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
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

2781 Townline Road, Alden, NY 14004, USA.

Phone : (800) 999-3463; International Phone : +1-(716)-683-8334
Fax : (800) 533-6657; International Fax : +1-(716)-683-5433
E mail: sales@unitedpmr.com; Website: www.unitedpmr.com