

---

## UNITED "WHITE" ALLOY # ASTRIMUM-2

Thank you for using UNITED'S alloys.

UNITED'S # **ASTRIUM-2** is a custom made - Palladium based white alloy is a nickel free white master alloys. **Astrium-2** is designed for **14 K casting** but may be used for **18 K** casting also. The color produced will be a **White**, which should be Rhodium plated for optimum color. **Astrium-2** alloy can be used in regular investment, but is somewhat better using Phosphate bonded investment.

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 **1130° - 1140° C**  
**2066° - 2084° F**
- Step : 2** Casting Temperature for 14 K – 18 K Alloyed Grain **1120° - 1130° C**  
**2048° - 2066° 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

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 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. Reuse will be limited to a few melts.

### 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)

---

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](mailto:sales@unitedpmr.com); Website: [www.unitedpmr.com](http://www.unitedpmr.com)