



## UNITED ALLOY # 634

Be insured in quality, Be insured in service, Be insured in "United Alloys."

**UNITED ALLOY** is uniquely different from other available alloys. Combining the highest purity metals available, stringent quality control, special de-oxidizers and grain refiners, produce trouble-free, superior quality castings and fabrication or rolling (hand-made).

**UNITED ALLOY # 634** is designed for 9K - 18K Pink Gold, which produces a Rose Pink Color. This alloy is making tremendous strides in the technical metal development of a cracking free pink gold alloy and contains grain refiner which make better solidification characteristics to eliminate the cracking problem and reduce the porosity which improve the quality of casting and provide high luster in finished color and can be used Regular Casting, if desired.

- 1.) **MELTING** : The # 634 Alloy, and fine gold should be melted together in a clean crucible. Put alloy in the bottom of the crucible and fine gold on top. The melting temperature for alloying should be 1,020 - 1,050 °C. Boric acid flux may be used to keep the metal clean during the melting process. The metal should be mixed well with a stirring rod before pouring to assure a good mix.
- 2.) **POURING** : Metal should be poured into a preheated, vertical graphite or lightly lubricated iron mold. A steady even pouring motion should be used slowing down at the end of the pour to prevent shrinkage in the top of the ingot. Use a round rod mold for wire and a 2 piece L shaped mold for plate and sheet.
- 3.) **QUENCHING** : The ingot should be removed from the mold and quenched immediately in pickle solution or water. For heavy ingots a one-minute cool down before quenching prevents quench cracking.
- 4.) **FABRICATION** : The metal ingot should be cleaned of all adhering oxide or fluxes before rolling. The ingot should be rolled or drawn to a 50% reduction in size before annealing. After annealing continue the reduction at 50% before annealing again. Clean the ingot after each anneals. Keep rolls, dies and metal clean to prevent defects in the finished stock.
- 5.) **ANNEALING** : Annealing temperature 675 °C for 20 minutes. Quench immediately in water or pickle solution. A boric acid fire coat should be applied before annealing in open atmosphere ovens to protect the metal from heavy oxidation. Avoid over-annealing wire or plate stock as this can cause excessive grain growth creating orange peel effect on the surface of finished goods.
- 6.) **PICKLING** : United's Brite-Cast™ (Ammonium Bi-fluoride), Sparex # 2 (sodium bisulfate), 10% - 20% Sulfuric Acid.  
Rubber gloves and safety glasses are recommended when using acid pickle.
- 7.) **RE-USING** : New alloy and fine gold 50% and Old gold 50%, Cleans Old gold well before re-melting.
- 8.) **SOLDERING** : United # 11SA, # 12SA or already mixed solder sheet, Laser welding is for matching red/pink color.
- 9.) **NOTES** : Melt temperature may vary with type of unit.

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