



UNITED ALLOY # RM-60

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 # RM-60 is designed for 18K - 19K Nickel Safe White Gold, which produces a Premium White Color. This alloy is making tremendous strides in the development of a very white color and high fluidity white gold alloy which contains technical metal or special elements which resist oxygen absorption in melting process and better solidification characteristics to reduce the porosity which improve the quality of casting and provide high luster in finished color. This alloy will provide in foils / small sheet from.

We do recommend pre-graining all alloy and fine gold before casting to assure a uniform mixture.

1.) Melt Temperature for Alloying : 1,090 - 1,100 °C

2.) Melt Temperature for Casting : 1,040 - 1,050 °C

3.) Flask Temperature :

KARAT	WEIGHT	VACUUM CAST
18K - 19K	Light	680 - 720 °C
	Medium	620 - 650 °C
	Heavy	550 - 600 °C

Normal recommended temperature in the range of 650 - 700 C depending on size of flask & type of Jewelry

4.) Quench Time : After casting, wait 20 - 25 minutes (Quench Button first in water).

5.) Pickle : 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.

6.) Reused : New alloy and fine gold 70% and Old gold 30%, Cleans Old gold well before re-melting.

7.) Specific Gravity : 18K - 14.65, 19K - 15.39

8.) Soldering : United White Solder Alloy # 6SA, # 7SA, # 8SA, # 18WSAE or already mixed gold solder sheet.

Laser welding is recommendation for matching metallic white color.

9.) Nickel Release Test EN1811:2011 + A1:2015 (Micrograms / Square Centimeter / Week) : 18K & 19K Compliant.

10.) Notes : Melt temperature may vary with type of unit.

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