



UNITED ALLOY # ROM-2

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 # ROM-2 is designed for 8K-14K Nickel Free White Gold, which produces a White Color and a slight greenish color in 14K. This alloy is making tremendous strides in the technical metal development of a very high fluidity white gold alloy and contains Grain refiner which improves flexibility in rolling process and better solidification characteristics to reduce the porosity which improve the quality of casting and provide high luster in finished color and can be used Regular Casting, Stone-In-Place Casting and Rolling (hand-made)

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

- 1.) Melt Temperature for Alloying : 1,030 - 1,040 °C
- 2.) Melt Temperature for Casting : 990 - 1,010 °C
- 3.) Flask Temperature :

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
8K - 14K	Light	530 - 550 °C	620 - 680 °C
	Medium	490 - 520 °C	550 - 590 °C
	Heavy	450 - 480 °C	480 - 540 °C

- 4.) Quench Time : After casting, wait 15 - 20 minutes before quenching flask.
- 5.) Pickling : United's Brite-CastTM (Ammonium Bi-fluoride), Sparex # 2 (sodium bisulfate), 10% - 20% Sulfuric Acid.
Rubber gloves and safety glasses are recommended when using acid pickle.
- 6.) Re-using : New alloy and fine gold 50%, Old gold 50%, Cleans Old gold well before re-melting.
- 7.) Specific Gravity : 8K - 11.97, 9K - 12.26, 10K - 12.57, 14K - 13.96
- 8.) Soldering : United White Solder Alloy # 5SA or already mixed gold solder sheet.
- 9.) Notes : Melt temperature may vary with type of unit.

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