



## UNITED ALLOY # SY-130

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 # SY-130 Yellow Silver Grain is a yellow alloy designed for casting to make yellow silver jewelry, samples, models, belt buckles, art objects, etc. It finishes to a yellow color and easily solders with brass, sterling silver and low gold formulas. This alloy contains a silicon de-oxidizer for clean casting. This alloy has 14% fine silver and is to be **directly** used for casting. Please note, this alloy is **NOT** recommended to hallmark or stamp "925" or "STERLING".

This Yellow Silver grain is already mixed can be used without adding any metal.

1.) Melt Temperature for Casting : 1,020 - 1,080 °C

2.) Flask Temperature :

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

3.) Quench Time : Wait 15 - 20 minutes before quenching flask.

4.) Pickling : United's Brite-Cast<sup>TM</sup> (Ammonium Bi-fluoride), Sparex # 2 (sodium bisulfate), 10% - 20% Sulfuric Acid.

Rubber gloves and safety glasses are recommended when using acid pickle.

5.) Re-using : We recommend a 75% fresh / 25% Scrap mix, Cleans scrap well before re-melting.

6.) Specific Gravity : 8.89

7.) Soldering : Ratio of Mixing : 70% United Silver Solder Alloy # SSA + 30% Fine Silver.

Laser welding is recommendation for matching yellow color.

8.) Note : Melt temperature may vary with type of unit.

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