



UNITED ALLOY # 738

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 # 738 is designed for Red/Pink Brass, which produces a Premium Red/Pink Brass Color for Casting the jewelry samples, models, belt buckles, art objects, etc. It finishes to a 14K Premium Red/Pink Gold Color and easily solders with sterling silver or low gold formulas. This Premium Red/Pink Brass is making tremendous strides in the technical metal development of a high fluidity and contains De-oxidizers which resist oxygen absorption in melting process and better solidification characteristics to reduce the porosity and clean casting which improve the quality of casting and provide high luster in finished color.

This alloy is already mixed can be used without adding any metal.

- 1.) Melt Temperature for Casting : 1,050 - 1,100 °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-CastTM (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 : New metal 70% and Old metal 30%, Cleans scrap well before re-melting.
 6.) Specific Gravity : 8.77
 7.) Soldering : Ratio of Mixing : 70% United Silver Solder Alloy # SSA + 30% Fine Silver.
 Laser welding is recommendation for matching red/pink color.
 8.) Note : Melt temperature may vary with type of unit.

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