



## UNITED ALLOY (YELLOW GOLD ALLOY) # 200 (9K-14K)

THANK YOU FOR USING UNITED'S ALLOYS.

UNITED'S # 200 ALLOY is designed for 9-14K yellow gold casting, which produces a greenish yellow color. This alloy contains De-oxidizers and can be used Normal and Stone-In-Place Casting.

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

Melt Temperature for Alloying : 1,030 - 1,065°C / 1,900 - 1,950°F

Melt Temperature for Casting : 990 - 1040 °C / 1,815 - 1,910 °F

Flask Temperature :

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
9K – 14K	Light	524 - 538°C (975 - 1,000°F)	621 - 677°C (1,150 - 1,250°F)
	Medium	482 - 510°C (900 - 950°F)	566 - 593°C (1,050 - 1,100°F)
	Heavy	455 - 482°C (850 - 900°F)	482 - 538°C (900 - 1,000°F)

Quench Time : After casting, wait 15 - 20 minutes before quenching flask.

Reused : We recommend a 50% fresh mix for remelting.

Fluxing : Boric Acid is the recommended flux for opened melting system. Use as little flux as possible.

Do not use carbon fluxes or any fluxes designed for refining; i.e., soda ash, saltpeter, etc.

Avoid flux in bottom pour automatic casting units.

Specific Gravity : 9K - 11.05, 10K - 11.37, 14K - 12.89

Soldering : United Yellow Solder Alloy # 1SA, # 2SA, # 3SA or already mixed gold solder sheet.

Notes : Melt temperature may vary with type of unit. This alloy is designed for casting only.

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