



**UNITED ALLOY (YELLOW GOLD ALLOY) # 460 (18K-22K)**

THANK YOU FOR USING UNITED'S ALLOYS.

UNITED'S # 460 ALLOY is designed for 18K-22K yellow gold casting, which produces a green yellow color.

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

Melt Temperature for Alloying : 1,050 - 1,070°C / 1,922 - 1,958°F

Melt Temperature for Casting : 1,025 - 1,035°C / 1,878 - 1,895°F

Flask Temperature

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
18K	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)
20K - 22K	Light	593°C (1,100°F)	705 - 732°C (1,300 - 1,350°F)
	Medium	566°C (1,050°F)	677 - 705°C (1,250 - 1,300°F)
	Heavy	538°C (1,000°F)	621 - 649°C (1,150 - 1,200°F)

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

**Reused** : We recommend 50% rejuvenation for remelting.

**Fluxing** : Boric Acid is the recommended flux. 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** : 18K - 15.63, 20K - 16.69, 22K - 17.90

**Soldering** : United Yellow Solder Alloy # 18YSAE or already mixed gold solder sheet.

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

Representative Office :

UNITED PM (THAILAND) CO., LTD. 427/15-16 Krungthonburi Rd., Klongtongsai, Klongsan, Bangkok. 10600, Thailand.

Tel : (662) 4400643, 4400673 Fax : (662) 8622344 Mobile 081-6948866, 081-7517384 E-mail : sales@unitedpmthailand.com