



UNITED ALLOY (PINK GOLD ALLOY) # 634 (9-18K)

THANK YOU FOR USING UNITED'S ALLOYS.

UNITED'S # 634 ALLOY may be used for 9K - 18K casting and hand-made (rolling), which produces a dark pink finished color. This alloy is making tremendous strides in the development of pink gold alloy.

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

Melt Temperature for Alloying : 1,050 - 1,060°C

Melt Temperature for Casting : 1,030 - 1,050°C

Flask Temperature :

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
9K – 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)

Quench Time : For 9-14K after casting, wait 15 minutes before quenching flask.

For 18K after casting, wait 5-10 minutes, quenching the button (only).

Then proceed to quench the whole flask.

Pickling : 10-20% Sulfuric acid or 50% Phosphoric acid.

Reused : We recommend a 50% rejuvenation for re-melting.

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

Specific Gravity : 9K - 11.23, 10K - 11.55, 14K - 13.05, 18K – 15.00

Soldering : United # 11SA & # 12SA pink solder alloy or United ready mixed karat pink gold solder.

Notes : Melt temperature may vary with type of unit. This alloy is designed for casting and can be used for fabrication.

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