



## UNITED ALLOY # 794 (18K-22K YELLOW ALLOY)

THANK YOU FOR USING UNITED'S ALLOYS.

UNITED'S # 794 ALLOY is designed for 18K-22K yellow gold casting, which produces a dark yellow color, popular in the middle-east.

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

Melt Temperature for Alloying : 18K    1,070 - 1,080°C    : 20K - 22K    1,100 - 1,130°C

Melt Temperature for Casting : 18K    1,000 - 1,010°C    : 20K - 22K    1,080 - 1,100°C

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 a 50% rejuvenation for re-melting.

**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 - 15.24, 20K - 16.40, 22K - 17.73

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

**Notes** : Melt temperature may vary with type of unit.

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