



**UNITED ALLOY # 796 (9K-14K PINK / 18K-22K REDDISH YELLOW)**

THANK YOU FOR USING UNITED'S ALLOYS.

UNITED'S # 796 ALLOY may be used for 9K-14K pink gold casting and rolling, which produces a light pink color in 18K and a reddish yellow color in 20K-22K.

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

Melt Temperature for Alloying : 9-18K 1,060 - 1,070°C : 20K - 22K 1,080 - 1,100°C

Melt Temperature for Casting : 9-18K 1,010 - 1,020°C : 20K - 22K 1,090 - 1,120°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)
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 : For 18K after casting, wait 3 - 5 minutes before quenching flask.

For 9-14K, 20K - 22K 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 : 9K - 11.39, 10K - 11.71, 14K - 13.20, 18K - 15.11, 20K - 16.29, 22K - 17.67

Notes : Melt temperature may vary with type of unit.

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