



UNITED # KARAT STERLING SILVER (Gold Sterling Silver)

UNITED KARAT STERLING SILVER is a proprietary of gold based sterling silver designed to good hardness and eliminate fire scale and porosity. KARAT STERLING SILVER has been developed to have a hardness exceeding standard sterling silver, while still retaining the advantageous characteristics of our other sterling silver grains.

Melting : Traditional methods of melting regular sterling silver I.E. (as cool as possible) will cause a variety of problems. Most failures with these sterling products are caused by too low of a melt temperature. Customers familiar with deoxidized gold casting alloys should have less trouble adjusting to the appearance of these silvers.

Casting Temperature : 980 - 1,020°C

Flask Temperature :

WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
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 20 - 25 minutes before quenching flask.

Reused : We recommend a 50% fresh – 50 scrap mix.

Fluxing : It will be necessary to flux these silver melts for opened melting system.

We recommend boric acid. Skim any surface oxides off the surface before stirring.

Investment Removal : Most standard investment removers will successfully remove the investment powder.

The best solutions are the sulfuric and hydrofluoric based products.

Soldering : United Silver Solder Alloy # SSA

Notes : Melt temperature may vary with type of unit.

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