



UNITED ALLOY # 741

Be insured in quality, Be insured in service, Be insured in “United Alloys.”

UNITED ALLOY is uniquely different from other available alloys. Combining the highest purity metals available, stringent quality control, special de-oxidizers and grain refiners, produce trouble-free, superior quality castings and fabrication or rolling (hand-made).

UNITED’S # 741 Bronze is an Antique Yellow Bronze for casting and provides a standard yellow antique bronze color. It may be used for resembling old bronze, costume jewelry, belt buckles, art objects and ect. This bronze has a much better resistance to tarnish than brass alloys, as well as a harder surface. It may be soldered with sterling silver by silver solders or low temperature copper base brazing alloys and 8-14K Low gold Formulas by low gold solders. Also, this bronze contains a silicon de-oxidizer for clean casting and greatly improves the cast ability.

This alloy is already mixed can be used without adding any metal.

1.) Melt Temperature for Casting : 1,050 - 1,100 °C

2.) Flask Temperature :

WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
Light	530 - 550 °C	620 - 680 °C
Medium	490 - 520 °C	550 - 590 °C
Heavy	450 - 480 °C	480 - 540 °C

3.) Quench Time : Wait 15 - 20 minutes before quenching flask.

4.) Pickling : United’s Brite-Cast™ (Ammonium Bi-fluoride), Sparex # 2 (sodium bisulfate), 10% - 20% Sulfuric Acid.

Rubber gloves and safety glasses are recommended when using acid pickle.

5.) Re-using : We recommend a 70% fresh / 30% Scrap mix, Cleans scrap well before re-melting.

6.) Specific Gravity : 8.69

7.) Soldering : Ratio of Mixing : 70% United Silver Solder Alloy # SSA + 30% Fine Silver.

Laser welding is recommendation for matching color.

8.) Note : Melt temperature may vary with type of unit.

Representative Office : UNITED PM (THAILAND) CO., LTD.

467/7 2nd Floor, Mahatun Rama 3 Center, Rama 3 Road, Bang Khlo, Bang Kho Leam, Bangkok. 10120, Thailand.

Tel : (662) 292 1992, 292 1993 Fax : (662) 292 1994 Mobile 081-751 7384 E-mail : sales@unitedpmthailand.com