



UNITED ALLOY # 805

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 ALLOY # 805 is designed for 19K - 22K Yellow Gold, which produces a Greenish Yellow Color. This alloy contains Technical Element Metals which improves flexibility in rolling process and better solidification characteristics to reduce the porosity, provide high luster in finished color and can be used Regular Casting, if desired.

This alloy is not recommended for 18 Karat.

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

- 1.) Melt Temperature for Alloying : 1,050 - 1,100 °C
- 2.) Melt Temperature for Casting : 1,090 - 1,120 °C
- 3.) Flask Temperature :

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
19K - 22K	Light	650 - 700 °C	680 - 720 °C
	Medium	620 - 650 °C	650 - 680 °C
	Heavy	600 - 620 °C	620 - 650 °C

- 4.) Quench Time : After casting, wait 15 - 20 minutes before quenching flask.
- 5.) Pickle : 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.
- 6.) Reused : New alloy and fine gold 50%, Old gold 50%, Cleans Old gold well before re-melting.
- 7.) Specific Gravity : 19K - 15.46, 20K - 16.10, 21K - 16.80, 22K - 17.55
- 8.) Soldering : United Yellow Solder Alloy # 18YSAE or already mixed gold solder sheet.
- 9.) Notes : 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@unitedpalthailand.com