



UNITED ALLOY # 869

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 # 869 is designed for 14K - 18K Nickel Safe White Gold, which produces a Yellowish White 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.

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

- 1.) Melt Temperature for Alloying : 1,030 - 1,050 °C
- 2.) Melt Temperature for Casting : 1,020 - 1,040 °C
- 3.) Flask Temperature :

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
14K - 18K	Light	570 - 600 °C	680 - 720 °C
	Medium	520 - 550 °C	620 - 650 °C
	Heavy	480 - 500 °C	550 - 600 °C

- 4.) Quench Time : After casting, wait 10 - 15 minutes before quenching flask.
- 5.) Pickling : United's Brite-CastTM (Ammonium Bi-fluoride), Sparex # 2 (sodium bisulfate), 10% - 20% Sulfuric Acid.
Rubber gloves and safety glasses are recommended when using acid pickle.
- 6.) Re-using : New alloy and fine gold 70%, Old gold 30%, Cleans Old gold well before re-melting.
- 7.) Specific Gravity : 14K - 12.77, 18K - 14.77
- 8.) Soldering : United # 6SA, # 7SA, # 8SA, # 18WSAE or already mixed gold solder sheet.
- 9.) Nickel Release Test EN 1811:2011 + A1:2015 (Micrograms / Square Centimeter / Week) : 14K - 18K Compliant.
- 10.) Notes : Melt temperature may vary with type of unit.

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