



## UNITED ALLOY # B-650

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 # B-650 Brass is a standard yellow brass designed for casting jewelry samples, models, belt buckles, art objects, etc. It finishes to a standard 14K color and easily solders with sterling silver or low gold formulas. The # B-650 has a much better resistance to tarnish than brass alloys, as well as a harder surface. This brass also contains De-Oxidizer for clean casting and greatly improves the cast ability for regular casting and stone set in place casting.

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 : 8.51
- 7.) Soldering : Ratio of Mixing : 70% United Silver Solder Alloy # SSA + 30% Fine Silver.
- 8.) Notes : Melt temperature may vary with type of unit.

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

467/7 2<sup>nd</sup> 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