



## UNITED ALLOY # 855

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 # 855 is designed for 9K - 14K Yellow Gold, which produces a Light/Pale 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.

- 1.) **MELTING** : The # 855 Alloy, and fine gold should be melted together in a clean crucible. Put alloy in the bottom of the crucible and fine gold on top. The melting temperature for alloying should be 1,020 - 1,050 °C. Boric acid flux may be used to keep the metal clean during the melting process. The metal should be mixed well with a stirring rod before pouring to assure a good mix.
- 2.) **POURING** : Metal should be poured into a preheated, vertical graphite or lightly lubricated iron mold. A steady even pouring motion should be used slowing down at the end of the pour to prevent shrinkage in the top of the ingot. Use a round rod mold for wire and a 2 piece L shaped mold for plate and sheet.
- 3.) **QUENCHING** : The ingot should be removed from the mold and quenched immediately in pickle solution or water. For heavy ingots a one-minute cool down before quenching prevents quench cracking.
- 4.) **FABRICATION** : The metal ingot should be cleaned of all adhering oxide or fluxes before rolling. The ingot should be rolled or drawn to a 50% reduction in size before annealing. After annealing continue the reduction at 50% before annealing again. Clean the ingot after each anneals. Keep rolls, dies and metal clean to prevent defects in the finished stock.
- 5.) **ANNEALING** : Annealing temperature 675 °C for 20 minutes. Quench immediately in water or pickle solution. A boric acid fire coat should be applied before annealing in open atmosphere ovens to protect the metal from heavy oxidation. Avoid over-annealing wire or plate stock as this can cause excessive grain growth creating orange peel effect on the surface of finished goods.
- 6.) **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.
- 7.) **RE-USING** : New alloy and fine gold 50% and Old gold 50%, Cleans Old gold well before re-melting.
- 8.) **SOLDERING** : United Yellow Solder Alloy # 1SA, # 2SA and # 3SA or already mixed gold solder sheet.
- 9.) **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 081-694 8866, 081-751 7384 E-mail : sales@unitedpmthailand.com