



UNITED ALLOY # 544

Thank you for using UNITED'S alloys.

UNITED'S 544 ALLOY may be used for 10K, 14K & 18K casting, which produces a pink / red finished color.

You should obtain excellent results by following a few simple instructions.

MELTING

Melt Temperature for 10, 14 & 18K Alloyed Grain 990° - 1020° C
1814° - 1868° F

Melt Temperature for Alloying 1040° - 1050° C.
1904° - 1922° F.

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

FLASK TEMPERATURE

We recommended a slightly higher temperature.

FLUXING

Boric Acid is the recommended flux. Use as little flux as possible. Do not use carbon fluxes or any fluxes designed for refining; i.e., soda ash, saltpeter, etc. Avoid flux in bottom pour automatic casting units.

QUENCH TIME

15 minutes for 10K & 14K
3 – 5 minutes for 18K

INVESTMENT REMOVAL

Most standard investment removers will successfully remove the investment powder. Fluoric-based investment removers are the best for removing the silicon oxide invisible coating. UNITED'S Brite-Cast Investment Remover also works very well.

RE MELTING

We recommend a 50% rejuvenation for remelting.

NOTES

Melt temperature may vary with type of unit. This alloy is designed for casting only.

TECHNICAL ASSISTANCE

Always available...
Call 1-800-999-3463 / 1-800-999-FINE.
E-mail / doc@unitedpmr.com
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