UNITED PRECIOUS METAL REFINING, INC.

UNITED ALLOY # 915

Thank you for using UNITED'S alloys.

UNITED'S 915 ALLOY may be used for 10K - 18K white gold casting, which produces a white finished color. #915 contains a silicon deoxidizer, and high nickel content.

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

MELTING

Melt Temperature for 10K Alloyed Grain	1050° - 1060° C. 1922° - 1940° F.
Melt Temperature for 14 & 18K Alloyed Grain	1030° - 1040° C. 1886° - 1904° F.
Melt Temperature for Alloying	1060° - 1070° C. 1940° - 1958° F.

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

FLASK TEMPERATURE

We suggest a slightly higher flask temperature for white gold.

FLUXING

Fluxing white gold is extremely important to pick-up oxides. Boric Acid is the recommended flux. 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

8 – 12 minutes.

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.

REMELTING

We recommend a 70% fresh - 30% scrap mix. White gold alloy has about 1/3 the reusability of yellow gold alloys.

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.
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