



### UNITED ALLOY # 922

Thank you for using UNITED'S alloys.

UNITED'S 922 ALLOY may be used for 14K - 18K white gold casting, which produces an extremely white finished color. The color of jewelry made with this alloy will fall in the Premium – Grade-1 category. Alloy #922 contains small amounts of cobalt to improve workability and silicon as a de-oxidizer.

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

#### **MELTING**

Melt Temperature for 14 & 18K Alloyed Grain 1040° - 1060° C.  
1904° - 1940° F.  
Melt Temperature for Alloying 1080° - 1090° C.  
1976° - 1994° 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 usually in the range of 1200 F to 1300 F for regular – non stone-in place castings.

#### **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**

10 – 15 minutes or as soon as the red glow disappears from button.

#### **INVESTMENT REMOVAL**

Most standard investment removers will successfully remove the investment powder. 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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