



UNITED ALLOY # M-930

Thank you for using UNITED'S alloys.

UNITED'S M-930 ALLOY may be used for 10K - 18K white gold casting, which produces a white finished color. #M-930 contains a silicon deoxidizer.

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

MELTING

Melt Temperature for 10K Alloyed Grain	1020° - 1030° C. 1868° - 1986° F.
Melt Temperature for 14 & 18K Alloyed Grain	1000° - 1020° C. 1832° - 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 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 10 – 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...
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