



United's Research & Development department has developed a user-friendly, hypoallergenic, Cobalt based Palladium-950 alloy called PD-950GR4 (patent pending).

This alloy does not become brittle upon continuous re-use and provides a bright white color in castings. Hardness of "as cast" pieces are in the range of 110 Hv to 115 Hv and shows good workability during gemstone settings, fabrication & assembly, repair & reconstruction and finishing. Jewelry made with this alloy will weigh approximately half of the weight in Platinum.

The PD-950GR4 alloy should be used to cast in a conventional "platinum casting equipment" and phosphate bonded (platinum investment) should also be used for investing the waxes. This alloy starts melting around 1360 °C and the recommended casting temperature is in the range of 1530 °C – 1600 °C. An argon cover gas is highly recommended while melting and casting this alloy to prevent oxygen and hydrogen absorption.

We also carry Ruthenium based PD-950 casting grain in "shot" and "rod" form. The shot form grain will provide excellent castings with good hardness (190 Hv to 220 Hv). The rod form is softer and is recommended for wire, sheet and tube making.

Solders for PD-950 in Easy, Medium and Hard solders are also available. Additionally, we also offer PD-950 refining for your scrap metal and bench sweeps.

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