

## Technical sheet - Alloy 384

Color - Dark Yellow

Purpose - All Purpose

Karat - 18K - 22K

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*	18K 384	14.79	18K 384	189
Cu	60.0%	18K 384	86.04	4.68	20.17	22K 384	17.53	22K 384	113
Ag	20.0%	22K 384	86.53	5.61	26.82				
Ga	10.0%								
Ni	10.0%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	18K - 22K	1110° - 1130° C	2012° - 2066° F
Casting	18K	920° - 940° C	1688° - 1724° F
	22K	1020° - 1040° C	1868° - 1904° F
Flask	18K - 22K	510° - 650° C	950° - 1202° F
Quench Time	15-20 Minutes	Remelting	50% Fresh Mix

### General Instructions

- Very little *boric acid* flux is recommended. Do not use carbon flux such as soda ash, saltpeter etc. No flux needed in bottom pour automatic casting unit.
- *Flouric based* investment removers are the best for silicon oxide invisible coating. Use of aggressive acid causes corrosion and surface damage. *United's brite cast* investment removers works effectively.
- To calculate the weight of the metal needed (in grams), *multiply density (gm/cc) with weight of wax (grams)*. Add 10% of the total weight for button.
- *Gypsum bonded* investment is recommended. Follow manufacturer's instruction for burnout cycle.

**Note:** There are proprietary metals in the formulation which are not included in the composition section.

**Technical Assistance:** Always available... Call 1-800-999-3463 / 1-800-999-FINE

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