

Technical sheet - Alloy ROM2

Color - Medium White (10K), Green (18K)

Purpose - Casting

Karat - 14K - 18K

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	1.20%	10K ROM2	94.03	-1.58	9.74	10K ROM2	12.56	10K ROM2	93
Ag	88.80%					18K ROM2	15.69	18K ROM2	79
Zn	10.00%								
Ni	0.00%								

Melting & Casting Instructions

Temperatures				
	Karat	°C	°F	
Pre alloying	10K	1030° - 1040° C	1886° - 1904° F	
	18K	1070° - 1090° C	1958° - 1994° F	
Casting	10K	970° - 990° C	1778° - 1814° F	
	18K	1045° - 1065° C	1913° - 1949° F	
Flask	10K - 18K	540° - 675° C	1004° - 1247° F	
Quench Time	25-30 Mins (10K), 8-10 mins (18K)		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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