Technical sheet - Alloy 930

Color - Ultra White
Purpose - Casting
Karat - 9K - 18K

Physical & Mechanical Properties

Composition	
Cu	57.00%
Ag	0.00%
Zn	21.00%
Ni	22.00%

Color Coordinates			
Karat	L*	a*	b*
10K 930	86.33	0.14	8.89
14K 930	86.56	0.8	10.2
18K 930	85.54	1.59	13.5

Density (g/cc)	
10K 930	10.99
14K 930	12.54
18K 930	14.58

As cast Hardness (HV)	
10K 930	164
14K 930	181
18K 930	226

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	10K	1060° - 1080° C	1940° - 1976° F
	14K - 18K	1050° - 1060° C	1922° - 1940° F
Casting	10K	1055° - 1075° C	1931° - 1967° F
	14K	1015° - 1035° C	1859° - 1895° F
	18K	990° - 1010° C	1814° - 1850° F
Flask	9K - 18K	540° - 675° C	1004° - 1247° F

Quench Time	10 - 12 Minutes

Remelting	70% 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 aggresive 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 manufacurer'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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