

CASTING ALLOY DATA

Alloy Name:	#467 WHITE
Description:	White casting alloy with excellent fluidity and reusability.
Karat:	10K, 14K
Karating:	Pre karating outside the casting machine is the preferred production procedure. Melt under a reducing or an inert atmosphere. Hold at pouring temperature for “2 minutes” when melt reaches 2010 to 2045F (1100 to 1120C). It is especially critical for white gold to make sure nickel is completely melted.
Casting:	Use a boric acid flux in an open system. Use a forming or argon Cover gas where possible. The casting temperature for 10k and 14k is 1830F – 1890F (1000C to 1015C).
Flask Temp:	Depending on the pieces being cast, a good starting point would be 1100F(593C) for 3dwt rings with detail. Use 950F(510C) for heavy rings.
Quench Time:	10 minutes after casting. 15 minutes for large castings (increasing quench time may harden metal).
Reusability:	A 70% new to 30% recycle ratio is recommended. Re-graining is not necessary.
Technical Questions:	Please feel free to call at any time if you have questions or comments.