

## CASTING ALLOY DATA #120YELLOW

Alloy Name:	<b>#120 Yellow</b>
General Description:	10-14 K. Yellow alloy for casting.
Karating:	Pre karating outside the machine is the preferred production procedure. Charge the alloy with the gold and cover with boric acid if a cover gas is not available. Mechanically stir the melted metal prior to shotting. Once metal reaches a temperature of 1050 C (1920 F), pour the shot.
Casting:	Melting should be done in an open atmosphere with boric acid flux. The casting temperature should be about 980C to 1000C for 14Kt. Add 20C for 10Kt.
Flask Temp:	Dependent upon the pieces being cast a good starting point would be 1100F (593C) for 3 dwt rings with detail, and 950F (510C) for heavy rings.
Quench Time:	15-20 minutes after casting.
Reusability:	A 50% fresh 50% recycle is acceptable, however a 60/40 is preferable. Regraining is not necessary.
Technical Questions:	Please feel free to call at any time if you have questions or comments.