

CASTING ALLOY DATA #850 WHITE

Alloy Name:	#850 – 8K, 9K, 10K, 14K White Casting Alloy
General Description:	Very soft & white (Nickel & Palladium Free) white casting alloy. Best results in 8K –10K product.
Color:	White
Karating:	Pre Karating is the preferred production procedure. Melting should be done in an inert atmosphere of Argon or Nitrogen. Charge alloy, cover with gold and cover gold with boric acid. Once metal reaches 1066 C (1950 F), stir & pour shot.
Casting:	Casting can be done in any atmosphere, the casting temperature should be about 1000-1040 C .
Flask Temp:	Dependent on parts a starting point would be: 600-640C for small rings with detail, and 480-540C for heavier pieces.
Quench Time:	20 - 25 minutes after casting.
Pickling:	Any typical investment remover should be used. Use proper gloves and Goggles should be worn.
Reusability:	A 60% fresh 40% recycle ratio is recommended. Regraining is not necessary.
Technical Questions:	Please feel free to call at any time if you have questions or comments.