

## CASTING ALLOY DATA SHEET #192

Alloy Name:	#192
General Description:	Non de-ox alloy for casting or rolling / extruding
Color:	Rich Yellow
Karating:	Pre karating outside the machine is the preferred production procedure. Charge the alloy with gold and cover with boric acid if a cover gas is not available. Mechanically stir the melted metal prior to shotting. Once the metal reaches a temperature of 1920F (1050C), pour the shot.
Casting:	Melting can done in an atmosphere with a boric acid flux. The casting temperature should be 1630F (890C) for 10K and 1610F (875C) for 14K
Flask Temp:	Dependent on on the sizes of the pieces being cast, a good starting point would be 1100F (595C) for 3 dwt ring with detail, use 950F (510C) for heavy rings.
Water Quench:	15 to 20 minutes after casting.
Pickling:	Investment Remover should be used. Heat is not necessary and proper safety gloves and goggles should be worn.
Reusability:	A 60% fresh 40% recycle ratio is recommended. Re-graining is not necessary.
Technical Questions:	Please feel free to call at any time if you have any questions or comments.