

## CASTING ALLOY DATA SHEET #850

Alloy Name:	#850 WHITE
General Description:	Very soft – White (Nickel and Palladium free) white casting alloy. Can be used for 8K, 9K, 10K and 14K, best results in 8K to 10K.
Color:	Good white color
Karating:	Pre karating outside the machine is the preferred production procedure. Melt under a reducing or an inert atmosphere. Hold at pouring temperature for “2 minutes” when melt reach 1950F (1060 C) stir and pour shot
Casting:	Casting can be in any atmosphere, the casting temperature should be about 1850F (1010C).
Flask Temp:	Dependent on parts, a starting point would be: 1100 F (593C) for 3 dwt rings with detail and 950 F (510C) for heavier pieces.
Water Quench:	20 to 25 minutes after casting.
Pickling:	Any typical investment remover should be used. Use proper gloves and goggles should be worn.
Reusability:	A 50% fresh to 50% recycle ratio is recommended. Regraining is not necessary.
Technical Questions:	Please feel free to call at any time if you have any questions or comments.