

ABI Precious Metals

Tech Specs: #120 - R

ALLOY: #120 YELLOW

DESCRIPTION: YELLOW ALLOY FOR ROLLING

KARAT: 10kt and 14kt

KARATING METHOD: Pre-karating outside the casting 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 1920°F (1050°C) pour the shot.

MELT TEMP: Melting can be done in any atmosphere with a boric acid flux. The melting temperature should be 1796°F to 1830°F (980° C to 1000° C) for 14 kt, 1830°F to 1868°F (1000°C to 1020°C) for 10kt.

REUSABILITY: A 50% new to 50% old is acceptable, however a 60/40 mix is preferable. Re-graining is not necessary.

TECHNICAL HELP: Please feel free to contact us any time with you questions or comments.

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