

ABI Precious Metals

TECH SPECS: # 18 S

ALLOY NAME	18 S
GENERAL DISCRIPTION:	White Bronze
COLOR:	White
LIQUIDUS:	2030°F (1110°C)
CASTING:	Melting should be done in an inert atmosphere (Argon, Helium or Nitrogen). The casting temperature should be about 2210°F (1210°C).
FLASK TEMP:	Depending on parts but a starting point would be 1300°F (704°C) for 3 dwt rings with detail, 1000°F (538°C) for heavy rings.
QUENCH TIME:	10 to 15 minutes minimum.
PICKLING:	Investment remover can be used. Proper safety gloves and goggles should be worn.
REUSABILITY:	A 60% fresh to 40% recycle is recommended. Re-graining is not necessary.
TECHNICAL HELP:	Please feel free to call at any time if you have questions or comments.

10/11