

# ABI Precious Metals

## #250 STERIALLOY ALLOYING INSTRUCTIONS

**MELT:** APPROX 875°C (1610° F)  
**PASTY RANGE:** 850°C TO 870°C (1562°F TO 1598°F)  
**ALLOYING TEMP:** 1010°C (1850°F)  
**CASTING RANGE:** 955°C TO 975°C (1750°F TO 1780°F)

- Layer the melt. Make a bed of 1/3 fine silver followed by all the Sterilite alloy.
- Put a tiny pinch of flux on the Sterilite. (Combine Borox and Boric Acid).
- Put remaining 2/3 of fine silver on top of the Sterilite alloy.
- Turn on power and take temperature to the alloying point of 1010°C (1850°F)
- Between the melt point 875°C (1610°F) and the alloying temperature of 1010°C (1850°F), either “pulse” the stirring feature if you have a Neutec....or stir the melt if you have a machine that is “melt accessible”.
- Shut off the machine after holding at 1010°C (1850°F) for 30 seconds. Allow melt to cool to 875°C (1610°F). Start the melt again and take up to 980°C (1796°F) and pour the shot.
- After you have cast the grain, open the machine and scrap any residue from the crucible into the slag catcher. This residue is natural and is a byproduct of the alloying process. It is an oxide that is given off during the melt and is harmlessly scraped away when the melt is finished.
- The grain does not need to be pickled, nor is tumbling needed. But if you do use Sodium Bisulfate (Sparex), tumble with Rollgleam or soap.

10/11

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