

ABI Precious Metals

TECH SPECS: # 2510

ALLOY NAME	2510
GENERAL DISCRIPTON:	White Bronze alloy 25% Silver
COLOR:	White
LIQUIDUS:	1770°F (966°C)
CASTING:	For best results melting should be done in an inert atmosphere (Argon, Helium or Nitrogen). The casting temperature should be about 1885°F (1030°C).
FLASK TEMP:	Depending on parts but a starting point would be 1200°F (650°C) for 3 dwt rings with detail, 1100°F (595°C) for heavy rings. Flask temperatures should be on a “trial and error” basis since all ovens are a little different.
QUENCH TIME:	20 - 30 minutes minimum (30 minute quench = harder pieces)
PICKLING:	Sparex (granular sodium bisulfate is recommended. Proper safety gloves and goggles should be worn. After pickling the sprues and trees to be re-cast should be tumbled and thoroughly rinsed and cleaned prior to re-casting.
REUSABILITY:	A 60% fresh to 40% recycle is recommended. It is imperative to “re-grain” the sprues and trees if you plan to reuse them to eliminate the sulfur dioxide from previous melts.
TECHNICAL HELP:	Please feel free to call at any time if you have questions or comments.