

ABI Precious Metals

Tech specs: 946 bronze

Alloy Name:	946 bronze
General Description:	Fluid, tin brass alloy for casting. Harder and more resistant to tarnish than regular art casting brass.
Color:	14K Yellow (tarnish resistant)
Casting:	Melting can be done in any atmosphere. Do not use flux
Casting Temp:	The casting temperature for heavy pieces should be 1900°F (1038°C) and up to 1980°F (1090°C) for lighter pieces.
Flask Temp:	Depending on parts but a starting point would be 1250°F (677°C) for 3 dwt rings with detail, and 1100°F (594°C) for heavy gents rings.
Quench Time:	20-25 minutes after casting. Do not quench too soon, the pieces will crack.
Pickling:	ABI Investment Remover or equivalent should be used. Heating is not necessary and proper safety gloves and goggles should be worn.
Reusability:	A 30% fresh 70% recycle ratio is recommended. Regraining is not necessary.
technical questions:	Please feel free to call at any time if you have questions or comments.