

ABI Precious Metals

Tech specs: 954 bronze

Alloy Name:	954 bronze
General Description:	Fluid, bronze alloy for casting. Harder than regular casting copper.
Color:	True bronze
Casting:	Melting can be done in any atmosphere. Do not use flux
Casting Temp:	The casting temperature for heavy pieces should be 1875 °F (1024°C) and up to 2100°F (1149°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.

