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# Sterling Silver Anti-Firescale Casting Grain #22

[Please Note: This casting grain is covered under one or more of the following #'s:  
U.S. Patent #4,973,446, #5,039,479 or International Publication #'s: WO 95/14112, & WO 96/22400]

Sterling Silver "22" is a proprietary deoxidized sterling silver designed to maintain maximum hardness while reducing fire scale and porosity. Sterling "22" maximizes hardness, color and reusability. By applying the know-how that has granted it two U.S. Patents, the manufacturer has developed a sterling silver with 90% of standard hardness, while retaining many of the characteristics of our other sterling silver grains.

Melting: Traditional methods of melting regular sterling silver I.E. (as cool as possible) will cause a variety of problems. Most failures with these sterling products are caused by using too low a melt temperature. Customers familiar with silicon deoxidized gold casting alloys should have less trouble adjusting to the appearance of these silvers.

<b>MELTING</b>	Temperature range: 990°–1020°C 1815°–1870°F
<b>REMELTING</b>	We recommend a 50% fresh mix. Our sterling silver replenisher can also be used without adding fresh.
<b>FLUXING</b>	It may be necessary to flux these silver melts. We recommend borax, boric acid or a 50/50 mixture. <b>Do not</b> use carbon-containing fluxes or charcoal. Skim any surface oxides off the surface before stirring.
<b>QUENCH TIME</b>	15–20 minutes.
<b>HARDNESS AND HEAT TREATMENT</b>	This silver as cast will have 90% of the hardness of traditional sterling silver. It can be hardened further by heat treatment at 300°C/575°F for 1 hour, and air cool.
<b>INVESTMENT REMOVAL</b>	Most standard investment removers will successfully remove the investment powder. Fluoric-based investment removers are the best for removing the silicon oxide invisible coating. Use of aggressive acids causes stress corrosion and surface damage and is therefore not recommended.
<b>FLASK TEMPERATURE</b>	Use your regular flask temperatures.
<b>FIRESCALE</b>	Firescale is completely eliminated.
<b>CYANIDE TREATMENT</b>	Not recommended.