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Sterling Silver De-Oxidized Casting Grain RWS1

This sterling silver de-oxidized casting grain is manufactured to resist tarnish, and eliminate porosity and fire scale. It is designed to reduce gas porosity, reduce shrinkage porosity, and to increase the overall success ratio of finished pieces.

PROCESS:	Every precaution is taken to ensure that the sterling you receive is of the finest quality. We perform an assay, a melt test, an oxygen test, and a visual inspection. Included in each shipment is a certified test report complete with lot numbers.	
COMPOSITION:	We start with only the best possible materials for this grain. The fine silver is electrolytically produced at the manufacturing facility and the purity of the silver is no less than 99.99% fine silver. The copper used is certified 99.9% pure and oxygen-free. The remaining elements contained in the metal are also of the best possible quality.	
PHYSICAL PROPERTIES:	Melting Point:	1515°F
	Flow Point:	1570° F
	Density:	5.372 troy ounces per cubic inch
	Form:	Shot
	Color:	Bright white metallic luster
	Hardness:	Rockwell 15T, hardness as cast 55–62
CASTING & CLEANING:	Recommended casting temperature is 1940°F. Recommended flask temperature is 1200°F. Please Note: This is very important to prevent cracking. A good cleaning solution for the cast silver pieces is a hot 10% (W/V) sodium bisulfate solution. This will remove the cupric oxide and leave a bright silver surface. Sodium bisulfate is more environmentally safe than sulfuric solutions. If further cleaning is required, mechanical means are recommended.	
RE-USE:	We recommend a 50% fresh mix. Remember to remove the copper oxides and investment from the surface.	
FIRESCALE:	Completely eliminated.	
SOLDER TREATMENT:	Due to the low melt and flow point of this alloy, we recommend jewelers easy and extra-easy silver solder be used for metal joining. The flow point of silver solders in this application should not exceed 1360°F.	
QUENCHING:	Wait 45 minutes before quenching.	