



UNITED # STAGCG-72 (STERLING SILVER CASTING GRAIN)

UNITED # STAGCG-72 is a De-oxidized Sterling Silver Grain designed to achieve tarnish resistance, eliminate fire scale and porosity. Sterling # STAGCG-72 has been developed to have hardness approximately equal to standard sterling silver, while still retaining the advantageous 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 too low of a melt temperature. Customers familiar with silicon deoxidized gold casting alloys should have less trouble adjusting to the appearance of these silvers.

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- Casting Temperature** : 990 - 1,020°C / 1,814-1870°F
- Flask Temperature** : Use your regular flask temperatures in the range of 1100 F to 1250 F depending on the size of flask and type of jewelry being cast.
- Quench Time** : 15 - 20 minutes.
- Specific Gravity** : 10.26
- Remelting** : We recommend a 50% fresh mix.
- Investment Removal** : Most standard investment removers will successfully remove the investment powder. The best solutions are the sulfuric and hydrofluoric based products.
- Fluxing** : It maybe necessary to flux these silver melts. We recommend Boric acid.
Do not use Carbon Containing Fluxes or Charcoal. Skim any surface oxides off the surface before stirring.
- Hardness and** : This silver as cast will have a hardness similar to traditional sterling silver.
- Heat Treatment** : It can be hardened further by heat treatment at 300°C/ 575°F for 2 hr., and air cool.
- Soldering** : Over-heating while soldering is to be avoided.
United # SSA is a silver solder alloy or ready to use Easy-Medium-Hard silver solder.
- Notes** : Melt temperature may vary with type of unit.
U.S. Patent # 4,973,446, # 5,039,479 or International Publication # 's WO 95/14112, & WO 96/22400

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