



## UNITED # STAGCG-88 (STERLING SILVER CASTING GRAIN)

UNITED # STAGCG-88 is a De-oxidized Sterling Silver Grain designed to achieve high tarnish resistance, improving hardness, eliminate fire scale and porosity. Sterling # STAGCG-88 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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<b>Casting Temperature</b>	: 990 - 1,020°C / 1,814-1870°F
<b>Flask Temperature</b>	: 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.
<b>Quench Time</b>	: 15 - 20 minutes.
<b>Specific Gravity</b>	: 10.27
<b>Remelting</b>	: We recommend a 50% fresh mix.
<b>Investment Removal</b>	: Most standard investment removers will successfully remove the investment powder. The best solutions are the sulfuric and hydrofluoric based products.
<b>Fluxing</b>	: It maybe necessary to flux these silver melts. We recommend Boric acid. <b>Do not use Carbon Containing Fluxes or Charcoal.</b> Skim any surface oxides off the surface before stirring.
<b>Hardness and</b>	: This silver as cast will have a hardness similar to traditional sterling silver.
<b>Heat Treatment</b>	: It can be hardened further by heat treatment at 300°C/ 575°F for 2 hr., and air cool.
<b>Soldering</b>	: Over-heating while soldering is to be avoided. United # SSA is a silver solder alloy or ready to use Easy-Medium-Hard silver solder.
<b>Notes</b>	: 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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