



## UNITED ALLOY # STERLIUM PLUS (STERLING SILVER GRAIN)

THANK YOU FOR USING "UNITED'S ALLOYS"

UNITED's Sterling Silver Grain "STERLIUM PLUS" is a proprietary deoxidized sterling silver designed to achieve maximum hardness and tarnish resistance. This product is recommended to be used ONLY in enclosed or automated casting equipments. Casting made with STERLIUM PLUS will exhibit a thin layer of whitish "Fire scale" which can be easily removed by picking / tumbling or finishing.

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- Specific Gravity** : 10.38
- Casting Temperature** : 990 - 1,020°C
- Flask Temperature** : Use your regular flask temperatures in the range of 450 to 650 °C depending on the size of flask and type of jewelry being cast.
- Quench Time** : After casting, wait 15 - 20 minutes before quenching flask.
- Investment Removal** : Most standard investment removers will successfully remove the investment powder. Fluoric-based investment removers are the best for removing the oxide invisible coating. Use of aggressive acids causes stress corrosion and surface damage and is therefore not recommended..
- Remelting** : We recommend a 50% fresh mix.
- Hardness and** : This silver as cast will have a hardness similar to traditional sterling silver.
- Heat Treatment** : Coat the jewelry with boric-acid or any oxidation preventing chemical.  
Place the jewelry in a furnace at 300°C/ 575°F for 1-2 hour followed by air cooling.
- Solder Treatment** : 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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