

Tech specs:954 SILICON Bronze

Alloy Name: # 954 SILICON Bronze

General Description: Low zinc, very fluid, low melting, lead free brass alloy for casting

Color: Bronze

Hardness: 167 Hv

Casting: Melting can be done in any atmosphere. **Flux not recommended.**

Casting temperatures for heavier pieces should be about 1800F (981C) and up to 1900F (1036C) for lighter pieces.

This alloy requires generous sprues to avoid shrinkage.

Flask Temp: Dependent on parts but a starting point would be 1100F (593C) for 3 dwt rings with detail, and 950-1000 F (510 – 538 c) for heavier rings, bracelets etc.

Quench Time: 20-25 minutes after castings. *Do not quench too soon, the pieces will crack.*

Pickling: Any typical investment remover should be used. Use proper safety gloves and goggles.

Reusability: A 70% fresh 30% recycle ratio is recommended. Regaining is not necessary.

Technical Questions: Please free to call at any time if you have questions or comments.