

Tech Specs: 2510

Alloy Name :	2510
Description :	White Bronze alloy 25% Silver
Color :	White
Liquidus :	1770F (966C)
Casting temp:	For best results melting should be done in an inert atmosphere (Argon, Helium or Nitrogen). The casting temperature should be about 1885F (1030C)
Flask Temp. :	Depending on parts but a starting point would be 1200F (650C) for 3dwt rings with detail, and 1000F (537C) for heavy gents rings. Flask temperatures should be on a “trial and error” basis since all ovens are a little different.
Quench Time :	20-30 minutes minimum (30 minute quench = harder pieces)
Pickling :	Sparex (granular sodium bisulfate is recommended. Proper safety gloves and goggles should be worn. After pickling the sprues and trees to be re-cast should be tumbled and thoroughly rinsed and cleaned prior to re-casting.
Reusability :	A 60% fresh 40% recycle recommended. It is imperative to “ re-grain” the sprues and trees if you plan to reuse them to eliminate the sulfur dioxide from previous melts.
Technical :	Please feel free to call if you have any technical questions or comments.