

INSTRUCTIONS FOR MASTER ALLOY #S-95

S-95 is a **New Age -master alloy** for adding to fine silver to make Sterling Silver. Based on our proprietary Sterling Silver, this master alloy was developed for those who wish to alloy their own sterling. **# S-95** will cast without fire scale. The advantages over standard sterling are: **Reduced gas porosity.** **# S-95** contains deoxidizers which resist oxygen absorption. **Reduced shrinkage porosity.** Better solidification characteristics reduce shrinkage porosity.

MIXING Use 92.5% fine silver & 7.5% **S-95**. (We recommend using 92.7% fine silver & 7.3% **S-95**). Example: 500 gms, add 462.5 gms of fine silver & 37.5 gms of **S-95**.

MELTING We do recommend pre-alloying all master alloy with fine silver followed by aggressive stirring & fluxing to assure a uniform mixture before using it for casting.

Step : 1 Pre- Alloying (Fine silver + master alloy) Temperature **1035° - 1045° C**
1895° - 1913° F

Step : 2 Casting Temperature for ingots or bars **1020° - 1040° C**
1868° - 1904° F

Temperature for continuous casting **980° to 1020° C**
1796° to 1868° F

Temperature for static casting in bars **1020° to 1040° C**
1868° to 1904° F

Ingot molds should be well heated to **121° C / 250° F** before pouring metal.

RE MELTING: We recommend a 50% Fresh / 50% Scrap mix. Clean scrap well before re-melting.

FLUXING: We recommend a Boric Acid flux, skim off any surface oxides before pouring. Carbon or charcoal fluxes are not recommended.

QUENCHING: Cast ingots may be quenched immediately.

PICKLING: Hot Sparex solution (sodium bisulfate) or 10% Sulfuric Acid can be used as a pickle.

FABRICATION: Use the same fabrication procedures as those used on regular Sterling Silver.

ANNEALING: Coat the jewelry items with boric acid or any oxidation preventing solutions available. A 20 minute anneal at **700° C / 1292° F** followed by water quenching.

HARDENING: Place in a pre-heated oven set at **300° C / 575° F** for 1 hour and air cool.

TECHNICAL ASSISTANCE Always available... Call 1-800-999-3463 / 1-800-999-FINE
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