

## KARATSTERL

Purpose - Casting

Advantages - Heat treatable, high tarnish resistance

### Physical & Mechanical Properties

Composition		Density (g/cc)	Hardness (HV)	
Ag	92.50%		10.28	As cast
Cu	4.55%	1 stage hardened		81
Zn	2.70%	2 stage hardened		93
Au	0.25%			

### Melting & Casting Instructions

Temperatures			Process parameters	
<b>Casting</b>	960° - 990° C	1760° - 1814° F	<b>Quench Time</b>	20-25 minutes
<b>Flask</b>	540° - 650° C	1004° - 1202° F	<b>Remelting</b>	50% fresh mix

### Heat treatment Instructions

**(1) 1 Stage Hardening process for medium to high hardness:**

Heat the sample at 450° C for 1 hour and air cool.

**(2) 2 Stage Hardening process for super high hardness:**

Stage 1 - Anneal the sample at 700° C for 15 - 25 minutes (depending on the size) & quench in water.

Stage 2 - Heat the sample at 450° C for 1 hour and air cool

**Note:** Cover the object with slurry of Borax / Boric acid paste to protect the surface from discoloration.

### General Instructions

- **Fluxing:** It may be necessary to flux these silver melts. We recommend Boric Acid. Do not use Carbon Containing Fluxes or Charcoal. Skim any surface oxides off the surface before stirring.
- **Investment removal:** *Flouric based* investment removers are the best for silicon oxide invisible coating. Use of aggressive acid causes corrosion and surface damage. *United's brite cast* works very effectively.
- To calculate the weight of the metal needed (in grams), multiply density (gm/cc) with weight of wax (grams). Add 10% of the total weight for button.

**Note:** There are proprietary metals in the formulation which are not included in the composition section.

Technical Assistance: Always available... Call: **1-800-999-3463 / 1-800-999-FINE**

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