



Data Sheet

Mokume-gane
Jazz & Bubble

RMS
Reactive Metals Studio Inc
RMS

PO Box 890
Clarkdale, AZ 86324
928/634-3434 • 800/876-3434 • 928/634-6734F
www.reactivemetals.com • info@reactivemetals.com

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COMPOSITION:

5 layers- 1 sterling, 1 copper, 1 shibuichi 15%, 1 shakudo 4% and a heavy sterling back.

APPROXIMATE MELTING POINT:

1432°F (778°C).

ANNEALING TEMPERATURE:

Use all chemical solutions with proper ventilation, safety equipment and supervision.

1250°F (676°C) for one minute. **Do not quench!** Pickle in 10% cold sulfuric acid or Sparex.

FABRICATION:

Note in the composition above that this laminate has very few layers. Stock removal by sanding or filing should be held to a minimum or loss of pattern may occur.

SOLDERING:

Use the same considerations as if soldering sterling silver. Easy and Medium solders should be used.

ETCHING:

Use all chemical solutions with proper ventilation, safety equipment and supervision.

Etching will open the surface for patination and provide some dimensional topography to the metal. Our "Multi-Etch" used cold is an excellent mordant. You may also use a 25% nitric acid solution. The silver will remain relatively untouched while the copper will be strongly etched. Take care not to over etch. Ferric chloride OR household ammonia, which are much safer and slower, may also be used. Please follow all safety procedures when using acids.

PATINATION:

Baldwin's Patina was formulated for this metal combination. For best results clean the surface well with soap to remove all oily contamination. Prepare the surface by rubbing with **No Name Patina Prep** or fine pumice.

Warm the metal under warm running water and shake off the excess. Gently rub a small amount of the solution on the whole surface and rinse. Continue alternating application with rinsing until the color is achieved. The copper should darken to a deep aged brown. The shakudo will turn black and the shibuichi will be grey/brown, all without affecting the sterling.

Traditional liver of sulphur can be used as a very dilute solution. Yellow stains on the sterling areas may be difficult to remove selectively. Household clear ammonia or ammonia vapors may also be used to produce a soft brown on the copper.*

*NOTE:

All patinas are temporary. The environment they live in will affect them in many ways. They will often respond to the chemistry of the wearer. Waxes and lacquers can be applied to help stabilize the colors but in themselves should be considered temporary fixes.