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Fig. 6.18 Normalized CR (N3h) and the evolution of the solid and primary austenite fractions (Alonso et al. 2012). With permission from the American Foundry Soc - "Science and Engineering of Casting Solidification"

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Common casting materials are aluminum, bronze, and brass. For investment casting, the first step is to create an alginate or silicone rubber impression of the object, so multiple wax replicas can be created. These wax objects are attached to a "tree" of wax, creating a structure that can be encased in plaster to make the final metal mold.

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