

## The Art of Lost Wax Casting

The Brass Baron specializes in premium brass sculptures and fountains. Every piece is hand made in the ancient “lost wax” method. This meticulous process ensures the remarkable detail and heirloom quality of every Brass Baron creation. Minor variations in look and finish occur normally, due to the individual crafting inherent in the process, and make each piece unique. This artistic and labor-intensive lost wax process creates sculptures of exceptional detail, value, durability and beauty.

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1. Working from Brass Baron sketches, artists sculpt the original work, and then create a mold by layering special latex rubber onto the original.



2. Liquid wax is painted and poured into the rubber mold, coating the mold's surface.



3. After hardening, the hollow wax impression is removed from the mold, and all details in the wax surface are perfected by hand; this makes each piece unique.



4. The finished wax impression is fitted with wax pipes, or sprues. The sprues allow air to escape during the brass pouring, preventing air bubbles in the finished piece.



5. The wax impression is then encased, inside and out, with a special mix of refined clay, which hardens into a mold.



6. The clay mold is fired in a kiln. The wax melts out of the clay mold. It becomes, in effect, “lost wax.”

7. The void created by the lost wax in the clay mold is then filled with molten brass, producing a piece that is identical to the wax impression it replaced.



8. The clay inside and surrounding the poured brass piece is delicately removed, revealing the raw cast sculpture.



9. Larger and more complex sculptures often require welding, since they are assembled from smaller cast pieces.



10. All pieces are sanded, smoothed and polished for a seamless look. An oxidizing formula is then applied to achieve a verdigris or golden bronze patina. A final wax coating is applied to protect the finish and seal the appearance.



## Brass and Bronze

Brass Baron bronze sculptures are hand made of the finest materials, and are described as both “brass” and “bronze”.

- “Brass” is primarily an alloy of copper and *zinc*.
- “Bronze” is primarily an alloy of copper and *tin*.

But besides having a *technical* definition, “Bronze” is also used to mean virtually any copper-based alloy. Thus, “brass” is commonly known as a *type* of bronze. Especially in art and sculpture, “bronze” is often used as the *general* term to describe brass statuary. Brass Baron bronze sculptures are made with approximately 70% copper.

Virtually all “bronze” statuary sold in the lawn and garden market is technically brass, regardless of the supplier. The sculptures are finished to replicate bronze, and are legitimately referred to as “bronze” in the general sense. If these product lines were literal museum quality bronze, they would be many times more expensive, since their copper content would be much higher and the alloy, with a higher melting point than brass, much harder to cast.

Over the past thirty years, the Brass Baron product line has evolved with sophisticated verdi finishes, which established the weathered bronze patina so popular today for outdoor metal statuary. This look, along with the rich brown finish of traditional bronze, is achieved with the artistic application of acid stains and polishes.

And, of course, Brass Baron sculptures are all hand made in the meticulous, centuries-old tradition of lost-wax casting, the ancient process that is common to creating both brass and bronze sculpture.

In short: ***Technically***, Brass Baron products are made of brass; ***Generally***, they can be described as bronze.