

tails of their operations. As the gold is brought to the Mint in various quantities and in a crude state, it passes necessarily through the department of the refiner before it reaches that of the chief coiner; I therefore give the actual details of the refining operations upon sundry deposits of gold, amounting in the aggregate to \$2,000,000.

The deposits are immediately weighed and a certificate of their gross weight issued. The fires having been lighted in the five furnaces of the deposit melting-room at four or five o'clock, A.M., all the deposits, amounting perhaps to seventy or eighty, are melted before noon; assay slips are then taken off and the assays finished * the next morning, after which their values are calculated by the weight after melting, care being taken to include all the grains that can be procured from the flux, pots, &c., by grinding them up under a pair of small chasers, sifting, and washing. There is a clerk and his assistant and one hand wholly engaged in performing all the weighings for the treasurer, such as weighing deposits before and after melting, ingots for coinage, fine bars, and the clippings after cutting out the planchets. There are five men in the deposit melting-room, two of whom attend to two furnaces each at the same time, one to one furnace and washing grains, and the remaining two are labouring assistants. The whole deposit of \$2,000,000 is melted in three or four days in the deposit-room and assayed by from the third to the seventh day.

As soon as the first deposits are assayed, say on the third day (if expedition is necessary), or always on the fourth, they are granulated in the proportion of one part of gold to two parts of silver. The pots contains 50 lb. of gold and 100 lb. of silver, equal to 1800 oz., and each melt requires about an hour. With four furnaces (attended by four melters and two aids), there are ordinarily made thirty-two melts per day, but when hurried forty-eight melts can be made, making from one-third of a million to one-half of a million dollars per day. Two days' work, or about \$650,000 worth of gold, equal in weight to one ton (avoirdupois weight), are granulated for a single setting with acid. The granulated metal is charged into large pots, together with pure nitric acid of 39° Beaumé, between the hours of seven and nine A.M. on the sixth day, and steamed for five hours. The pots made in Germany, are 2 feet in diameter by 2 feet in depth, set in plain wooden vats, lined with 3-sixteenth inch sheet-lead; a single coil of copper pipe passing around the bottom of the vat blows the steam directly into the water in which the pots are set to about half their depth.

The vats are arranged in a small house in the middle of the room with a large flue connecting with the chimney-stack, so that when in action the odour of nitrous fumes is scarcely perceptible in the building. The \$2,000,000 require about sixty such pots; they are stirred about once each hour, say altogether five times with simple wooden paddles; the next day (seventh), the acid solution of nitrate of silver is drawn off by a gold-syphon into wooden buckets, and transferred to the large vat, in which it is precipitated by salt (chloride of sodium), and fresh acid added to the metals, now containing very little silver. Steaming for five hours on the seventh day completes the refining of \$650,000. Early on the eighth one pot is drawn off, washed with a little warm water, and the gold-powder transferred to a filter. Fresh granulations are put into this empty

pot, and the acid of the adjoining pot baled over upon them, and thus through the series, the whole being re-charged in from two to two and a-half hours. After steaming for five hours, the acid which contained but little silver from the preceding day becomes a nearly saturated solution of nitrate of silver. By this arrangement $4\frac{1}{2}$ lb. of nitric acid are consumed altogether for each pound of gold refined, and the latter is brought up to 990 at 993 m. fine,—rarely below 990. Thus every two days, 13,000 lb. of nitric acid are used. In the course of the last year 1,000,000 lb. of pure nitric acid, at seven cents per pound, equal to \$70,000, were consumed.

The gold is washed with hot water on the filter during the eighth day, and until it is sweet (say by 7 P.M.). The filter consists of two layers of tolerably stout coarse muslin, with thick paper between, in a tub with a false bottom, $2\frac{1}{2}$ feet in diameter and $2\frac{1}{2}$ feet deep, and mounted on wheels. One of the men remains, after washing hours, until, 7 P.M., when the watchman of the parting-room continues washing the gold and silver until sweet, i.e., until the wash-water ceases to colour blue litmus paper. Early on the ninth day the wet gold is pressed with a powerful hydraulic press, and the cakes then thoroughly dried on an iron pan, at a low red heat. This process saves wastage in the melting-pot, since there is no water remaining in the pressed metal to carry off gold in its steam. The same day (ninth) the gold is usually melted with a less proportion of copper than is requisite to make standard metal, and cast into bars, which are assayed by noon on the tenth. They are then melted with the proper quantity of copper, partly on the same day, partly early on the eleventh, and assayed and delivered to the coiner the same day. On the fourteenth they are ready for delivery to the treasurer as coins.

The silver solution drawn off from the pots is precipitated in a large wooden vat of 10 feet diameter by 5 feet deep, and the chloride of silver immediately run out into large filters [$6 \times 3 \times 14$] where it is washed sweet. The filter is covered with coarse muslin, and the first turbid water thrown back; the filter, which is on wheels, is then run over to the reducing vats, and the chloride shovelled into them. There are four such vats [$7 \times 4 \times 2$] made of wood and lined with lead, 1 inch thick in the bottom. A large excess of granulated zinc is thrown on the moist chloride in the vats, without the addition of acid; the reduction is very violent, and when it slackens, oil of vitriol is added to remove the excess of zinc. The whole reduction occupies a few hours, and after a night's repose the solution of mixed sulphate and chloride of zinc is run off into the sewer.

About 2 tons of zinc per \$1,000,000 of gold are employed; the silver, however, in this amount, say 10 per cent. by weight, should only take, by equivalents, about 2400 lb., so that nearly two equivalents of zinc for 1 equivalent of silver are used. This is found to be advantageous, as both time and space are greatly economised by this excess.

The day after the reduction the reduced silver is washed, and the second day it is pressed and dried by heat, the same hydraulic press as for gold being used, but with different drying-pans. The same silver is used again for making fresh granulations, but as it accumulates from the Californian gold, 10,000 or 20,000 are now and then made into coin, great care being taken in this case to avoid getting gold in it when drawing off the silver solution, and in the press.

Such are the actual working details in refining a specified amount (\$2,000,000) of gold, the first-third of which is de-

* The mode of assaying is according to the "wet process" of Gay Lussac. This is too well known to need description here.