



**!!!! WARNING !!!!**



**WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.**

**BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).**

**THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.**

**DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.**

**BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.**

**SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.**



# **CROWN ALLOYS**

## **COMPANY**

30105 STEPHENSON HWY.  
MADISON HEIGHTS, MI. 48071  
(248) 588-3790 • (800) 521-7878

## **Royal 55/45-10**

**Bare Copper-Nickel TIG Rod**

### **Typical Applications:**

**Royal 55/45-10** is excellent for making repairs on all types of cast iron especially where a good color match is important. It can be used to fill sand holes, repair cracks or build up undersized patterns, molds, or castings. **Royal 55/45-10** can also be used to repair some grades of nickel alloys.

### **Specifications:**

AWS A5.7  
ER CuNi

➤ Tensile Strength	Up to 60,000 PSI
➤ Color Match (cast iron)	Excellent
➤ Machinability	Excellent

### **Procedure:**

Clean joint area thoroughly. Remove all fatigued metal. Bevel heavy sections. Use DC straight polarity with argon shielding gas. Preheat and post-heat will be dictated by the base metal, type of weld and amount of deposit.

### **Sizes:**

1/16 x 36"  
3/32 x 36"  
1/8 x 36"