



!!!! 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**

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Royal 120FC and Crown 120

**High Strength Nickel Silver Brazing Alloy
For Torch Application**

Typical Applications:

Royal 120FC (flux coated) and Crown 120 (bare) are excellent for joining both ferrous and non-ferrous metals (except white metals). Because of their thin flowing characteristics, they may be used to replace more expensive silver alloys, where higher temperatures do not matter. The **Royal 120FC and Crown 120** are excellent build-up alloys as they work harden with use. When used to build-up worn or broken gear teeth they will outwear the original steel teeth.

Specifications:

AWS A5.8
RB CuZn-D

- Tensile Strength 115,000-125,000 psi
- Hardness 90-110 Brinell (as welded)
(work hardens up to 220 Brinell)
- Working Temperature 1300°F to 1750°F
- Remelt Temperature 1750°F minimum

Procedure:

Clean joint area. For high strength joining, make sure a close fit is maintained. Heat joint area to dull-red. When using the **Royal 120 FC**, melt off small amount of flux and alloy then continue to heat until alloy flows. If the bare **Crown 120** rod is used, it should be heated and dipped in **Royal Tiger Flux #3**.

Sizes:

Royal 120 FC

3/32 x 18"
1/8 x 18"
3/16 x 18"

Crown 120

1/16 x 36"
3/32 x 36"
1/8 x 36"
3/16 x 36"
1/4 x 36"