



!!!! 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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Crown 15

1¼ Chrome - ½ Moly for Tig

Typical Applications:

Crown 15 is excellent for Tig welding Chrome Moly Steels used in pressure vessels and high pressure pipe. Also excellent for Chrome Moly castings where the base metal contains up to 1½% Chrome and ½% Moly. **Crown 15** is heat-treatable.

Specifications:

AWS A 5.28	Silicon	0.40-0.70
ER 80S-B2	Carbon	0.07-0.12
	Manganese	0.40-0.70
	Phosphorus	0.025
	Sulfur	0.025
	Nickel	0.200
	Chromium	1.20-1.50
	Molybdenum	0.40-0.65
	Copper	0.350
	Others	0.500

- Tensile Strength* 80 to 85,000 PSI
- Yield Strength 68 to 71,500 PSI
- Elongation 21%

*Post weld heat treated between 1125°F and 1175°F for one hour.

Procedure:

Clean weld area thoroughly. Preheat parts to be welded 250°F to 300°F. Use DC straight polarity with argon shielding gas.

Sizes:

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