



!!!! 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 119-T

Nickel Base Hard Overlay for Torch or TIG

Typical Applications:

Royal 119-T is used for building up and overlaying surfaces subjected to extreme abrasive wear. It is used on cams, rocker arms, augers, etc. Especially good for parts exposed to elevated temperatures. **Royal 119-T** is self-fluxing.

Specifications:

- Hardness 56-62 (Rockwell C) as welded.
Retains hardness up to 1000°F.
- Oxidation Resistance Good up to 1800°F
- Corrosion Resistance Has good resistance to salt water, steam, mild acids and many corrosive chemicals.

Procedure:

Clean base metal thoroughly. Apply alloy with a brazing technique using a neutral flame. Alloy will flow out at 1800°F to 1900°F. **Royal 119-T** can also be TIG welded with an argon shielding gas.

Size:

3/16