



!!!! 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 13-29 FC

Hardfacing Flux Cored Wire

Typical Applications:

Royal 13-29 FC is a high quality, flux-cored, all-purpose hardfacing wire with excellent welding characteristics. It is a high carbon and chromium alloy. These primary chromium carbides are able to withstand severe abrasion while still resisting moderate impact.

Specifications:

- Hardness as welded:
 - 1 Pass 52-57 (Rockwell C)
 - 2 Passes 58-61 (Rockwell C)
 - 3 Passes 59-64 (Rockwell C)

Procedure:

Clean weld area. Use DC reverse polarity. Weld with either stringer beads or slight weave motion. A constant potential or controlled voltage power source and wire feeder will give best results. If hard facing low to medium carbon steels, a preheat is not required. If hard facing high carbon steels, the preheat and interpass should be that which is required to produce an optimal 3/8" to 5/8" average distance between stress relief checks. If more than 3/16" build up is needed use **Royal 13-25 FC** as a cushion.

Sizes	Shielding Gas	Welding Current (amps)	Arc Voltage (volts)	Stickout (inches)
.045 x 25#	Not necessary , however best bead appearance is achieved using 100% CO₂ or 75%Ar-25%CO₂ (less spatter)	150 - 200	22-24	1¼"
1/16 x 25#		220 - 260	25 - 27	1¼"

Also available in 2# and 8" spools.