



**!!!! 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 R AZ92A** 36" Bare Magnesium TIG Wire

### **Typical Applications:**

**R AZ92A** is used to weld magnesium alloys - AZ10A, AZ31B, AZ61A, AZ80A and ZK21A - Cast alloys AM100A, AZ63A, AZ 81A, AZ91C and AZ92A. **R AZ92A** is also best to use when in doubt of base metal chemistry or when welding dissimilar magnesium alloys.

### **Specifications:**

AWS A5.19

Mechanical properties of magnesium welded joints will vary depending on the chemical composition of the base metal. Approximate weld properties would be:

- Tensile Strength            35,000 PSI
- Yield Strength             22,000 PSI
- Elongation in 2"            4%

### **Procedure:**

Clean area to be welded, removing all surface oxides. Preheat base metal to 400°F. Use argon shielding gas and **AC current**. Peen weld while still hot in order to relieve stress. Allow to cool slowly after welding. A post weld heat treatment is recommended to achieve maximum tensile strength.

### **Sizes:**

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