



**!!!! 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**

30105 STEPHENSON HWY.  
MADISON HEIGHTS, MI. 48071  
(248) 588-3790 • (800) 521-7878

## **Royal 44-30**

Premium Nickel-Iron-Manganese MIG Wire

### **Typical Applications:**

**Royal 44-30** is excellent for making repairs on all ductile and malleable irons. **Royal 44-30** is also useful for the welding of other high-strength nodular and gray cast irons where maximum strength and ductility are required. The addition of manganese provides superior wetting and crack-resistant weldability on even the most difficult cast iron applications. The **Royal 44-30** is also used for surfacing to improve wear resistance or for buildup. Also best for welding steel or stainless steel to cast iron.

### **Specifications:**

AWS A5.15-90  
ER NiFeMn-CI

➤ Tensile Strength	100,000 PSI
➤ Yield Strength	65,000 PSI
➤ Elongation	35%
➤ Color Match	Excellent
➤ Machinability	Excellent

### **Procedure:**

Prepare area to be welded by grinding or cleaning as well as possible. Bevel joint to form a "U" groove. Preheat and postheat treatments are not usually required. However, large complicated sections that are fully restrained will have a better chance of not cracking when preheated. DC reverse polarity with constant voltage is required. Shielding gas should be argon or CO<sub>2</sub> or a 75% Argon/25% CO<sub>2</sub>. Please see the **Royal 44-30** supplement (next page) for welding parameters.

### **Sizes:**

.035 x 30#  
.045 x 30#

Also available in 2# and 8" spools.

# **CROWN ALLOYS**

## **COMPANY**

30105 STEPHENSON HWY.  
MADISON HEIGHTS, MI. 48071  
(248) 588-3790 • (800) 521-7878

### **Royal 44-30**

Premium Nickel-Iron-Manganese MIG Wire

## **Typical Welding Parameters**

<b>.035 Wire Diameter (GMAW)</b>					
<b>SHIELDING GAS</b>	<b>WELDING CURRENT (AMPERAGE)</b>	<b>ARC VOLTAGE (VOLTS)</b>	<b>WIRE FEED SPEED (IPM)</b>	<b>TRAVEL SPEED (IPM)</b>	<b>ELECTRODE EXTENSION (INCHES)</b>
<b>75% Argon 25% CO<sub>2</sub></b>	130	24	300	15	1/2
	160	25	400	15	1/2
	180	26	500	15	1/2
	200	27	575	15	1/2
<b>CO<sub>2</sub></b>	125	24	300	15	1/2
	155	25	400	15	1/2
	180	26	500	15	1/2
	200	26.8	575	15	1/2
<b>Argon</b>	150	26	300	15	1/2
	190	27	400	15	1/2
	220	28	500	15*	1/2
	250	29	575	15*	1/2

\* Spray Transfer

<b>.045 Wire Diameter (GMAW)</b>					
<b>SHIELDING GAS</b>	<b>WELDING CURRENT (AMPERAGE)</b>	<b>ARC VOLTAGE (VOLTS)</b>	<b>WIRE FEED SPEED (IPM)</b>	<b>TRAVEL SPEED (IPM)</b>	<b>ELECTRODE EXTENSION (INCHES)</b>
<b>75% Argon 25% CO<sub>2</sub></b>	180	27	250	15	5/8
	190	28	300	15	5/8
	220	29	350	17	5/8
	240	30	400	20	5/8
	280	32	500	25	5/8
<b>CO<sub>2</sub></b>	165	26	250	15	5/8
	180	27	300	15	5/8
	220	28	350	17	5/8
	230	29	400	20	5/8
	270	31	500	25	5/8
<b>Argon</b>	190	27	250	15	5/8
	220	28	300	15	5/8
	240	29	350	17*	5/8
	275	30	400	20*	5/8
	310	32	500	25*	5/8

\* Spray Transfer