



**!!!! 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 205**

**Premium Low Hydrogen  
Iron Powder Coated Electrode**

### **Typical Applications:**

**Royal 205** is excellent for all position welding of carbon steels, low alloy steels, enameling steels, and steels high in sulfur, phosphorus or other elements added to improve the machinability of the steel. Deposits have good ductility, are dense, crack-free and of x-ray quality. **Royal 205** will work on crack-sensitive steels where regular mild steel electrodes fail. Used for the fabrication of "H" and "I" beams, pipelines, angle and channel iron. Superior impact resistance at normal and sub-zero temperatures.

### **Specifications:**

- Tensile Strength                      Up to 78,000 PSI
- Yield Strength                         Up to 67,000 PSI
- Elongation in 2"                        28-32%
- **Current AC or DC reverse polarity**

### **Procedure:**

Clean weld area thoroughly. Hold a short arc and use stringer beads for best penetration. Vertical joints should be welded from bottom up, using rapid weave technique.

### **Sizes:**

3/32	70-120	AMPS
1/8	100-150	AMPS
5/32	120-200	AMPS
3/16	150-220	AMPS

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## **Royal 205 TIG**

**Typical Applications:**            Same as **Royal 205**

**Specifications:**                    Same as **Royal 205**

### **Procedure:**

Clean weld area thoroughly use DC straight polarity with argon or argon mix shielding gas. Balance of the procedure is the same as **Royal 205**.