



**!!!! 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 208**

**Premium High Strength Low Hydrogen Electrode**

### **Typical Applications:**

**Royal 208** is excellent for use on high strength low alloy steels. It is used where good ductility and high tensile strength are desirable. **Royal 208** can be used as an excellent build up rod as a base for **Royal 240** on hard-facing applications. **Royal 208** will respond to heat treatment and can be flame cut.

### **Specifications:**

- Tensile Strength                      Up to 113,000 PSI
- Yield Strength                         Up to 104,000 PSI
- Elongation in 2"                        30%

### **Procedure:**

Clean weld area thoroughly. Use AC or DC reverse polarity. Use a short arc. Use stringer beads for best penetration on horizontal welds. Use weave technique working from bottom up for vertical welding. Remove slag between passes.

### **Sizes:**

3/32    60-110    AMPS  
1/8     100-150   AMPS  
5/32    120-180   AMPS  
3/16    150-200   AMPS

---

## **Royal 208 TIG**

**Typical Applications:**            Same as **Royal 208**

**Specifications:**                    Same as **Royal 208**

### **Procedure:**

Clean weld area thoroughly use DC straight polarity with argon or argon mix shielding gas. Balance of procedure is the same as **Royal 208**.