



!!!! 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 12-HW-10

Premium 36" Bare TIG Wire (Machinable Hot-Work Tool Steel)

Typical Applications:

The **Crown 12-HW-10** is used where tough, wear resistant welds that have good thermal shock resistance are needed. Used to repair or reclaim damaged and worn dies where heat checking due to water cooling is a problem and where machining in the as-welded condition is necessary. The **Crown 12-HW-10** will repair upsetter, press, hammer and insert forging dies as well as die casting dies and other hot and cold working units. Also good for welding broken teeth in transmission type gears.

Specifications:

- | | |
|--------------------|------------------------------|
| ➤ Tensile Strength | 85,000 psi |
| ➤ Hardness | 38-42 (Rockwell C) as welded |
| ➤ Machinability | Good |

Procedure:

Prepare area to be welded by grinding out cracks and other defects. Remove all oxides and other contaminants. Preheat and post heat according to base metal chemistry. Use DC straight polarity with argon shielding gas.

Sizes:

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

Identification: White End