



!!!! 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 AH-20

Premium Coated Electrode (Air Hardening)

Typical Applications:

For use on tools and dies of the 5% chrome type and the high chrome varieties. A-2 through A-5; also D-1 through D-7. Examples include extrusion dies, blanking dies, coining dies, mandrels and forming dies.

Specifications: (5% Chromium Air Hardening Tool Steel)

- | | |
|------------------|--|
| ➤ Hardness | 58-62 (Rockwell C) as welded |
| ➤ Heat Treatment | Preheat 5% chrome types to 600°F High carbon-high chrome types to 900°F |
| ➤ Forging Temps. | 1650°F to 1900°F |
| ➤ Annealing | Hardening in air 1700°F to 1775°F |
| ➤ Drawing | 350°F to 1000°F |

Procedure:

Prepare area to be welded by grinding out cracks and other defects. Remove all oxides and other contaminants. Preheat to recommended temperature. Use AC or DC reverse polarity, deposit short stringer type beads. Peen all deposits thoroughly. After welding, cool unit in still air.

Sizes:

| | | |
|------|---------|------|
| 3/32 | 50-80 | AMPS |
| 1/8 | 75-110 | AMPS |
| 5/32 | 110-140 | AMPS |

Identification: Red End