



**!!!! 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 CM-86-20**

Premium Chrome-Nickel-Moly Alloy Electrode

### **Typical Applications:**

**Crown CM-86-20** is excellent for buildup and joining on type 8620 steel plates, forgings and castings. It can be used as a buildup layer under harder weld deposits. Uses include the joining of low-alloy steels, pipe, and pressure vessels.

### **Specifications:**

- |                    |                    |
|--------------------|--------------------|
| ➤ Hardness         | 25-30 (Rockwell C) |
| ➤ Tensile Strength | Up to 105,000 PSI  |
| ➤ Machinability    | Excellent          |

### **Procedure:**

Use with AC or DC (reverse polarity). Remove all cracks and heat checks when using for overlay purposes. A 300°F-400°F preheat is necessary when welding on 8620. Cool in still air. Temper when necessary to base material.

### **Sizes:**

3/32	60-90	AMPS
1/8	75-135	AMPS
5/32	100-180	AMPS

**Identification:** Pink End