



!!!! 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

Crown CX-20

Electrode for Cast Iron Stamping & Forming Dies

Typical Applications:

Used primarily for the build up of wearing surfaces on all types of iron draw dies including grey, nodular, meehanite and special alloy cast irons. Used most often for welding flame-hardenable, automotive cast iron stamping and forming dies. The improved formulation of Crown CX-20 assures positive arc stability and instant restrike for difficult applications.

Specifications:

- | | |
|--------------------|--|
| ➤ Hardness | 34-36 (Rockwell C) as welded
37-40 (Rockwell C) work hardened |
| ➤ Tensile Strength | Up to 154,000 PSI |
| ➤ Elongation | Up to 35% |
| ➤ Machinability | Good |
| ➤ Heat Treatment | Non-heat treatable |

Procedure:

Prepare area to be welded by grinding out cracks and other defects. In many cases preheating is not necessary, although when needed 400°F is recommended. Be sure to peen between 4" stringer beads. Use 4" square patches when building up large surfaces to minimize localized heat input and avoid as many stresses as possible.

Sizes:

3/32	65-110	AMPS
1/8	90-135	AMPS
5/32	120-190	AMPS
3/16	170-220	AMPS

Identification: Light Green End