



!!!! 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 HS-7-10

Premium 36" Bare Shock Resistant TIG Wire

Typical Applications:

For use on shock resistant steels S-1 through S-7. For TIG (GTAW) welding on cold and medium hot working dies. Used on coining dies, trimmer dies, and especially good for high shock applications such as chisel points, hammer faces and punches.

Specifications:

- Alloy Type (Typical) AISI S-7
- Hardness 54-57 (Rockwell C) as welded. Can be tempered for lower hardness.

- Preheat The "S" series tool steels all require 300°F to 500°F preheat and post heat. The S-5 needs to be preheated to 500°F.

- Tempering S-1 300°F to 500°F
 S-2 300°F to 500°F
 S-3 300°F to 500°F
 S-4 300°F to 500°F
 S-5 500°F minimum
 S-7 400°F to 425°F

- Annealing 1,500°F to 1,550°F for one hour per inch of thickness

- Hardening 1,725°F

Procedure:

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

Sizes:

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

Identification: Light Blue End