



**!!!! 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 HW-20**

Premium Coated Electrode (Hot-Work)

### **Typical Applications:**

For use on hot working tool steels H-10 through H-12 and H-14 through H16. The **Crown HW-20** is often used to weld on SAE 52100 steel. It works very well on hot or cold work trimmers, shears, blanking, and forming dies when spalling, cracking and chipping are a problem.

**Specifications:** (Chromium Molybdenum-Tungsten hot working tool steel)

➤ Hardness	52-56 (Rockwell C) as welded
➤ Preheat	900°F
➤ Forging Temps.	1500°F to 1850°F
➤ Annealing	1500°F to 1550°F
➤ Hardening in Air	1800°F to 1900°F
➤ Hardening in Oil	1750°F to 1850°F
➤ Drawing	950°F to 1100°F

### **Procedure:**

Prepare area to be welded by grinding out cracks and other defects. Remove all oxides and other contaminants. Preheat to recommended temperature and maintain during welding. Use AC or DC reverse polarity. Deposit short stringer beads. Peen thoroughly. Cool in still air.

### **Sizes:**

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

**Identification:** Lavender End