



!!!! 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 NT-HW-20

Tungsten Free, Hot Work Tool Steel Electrode

Typical Applications:

The **Crown NT-HW-20** is designed to repair AISI H-13 hot work tool steel. For use on hot-work tools and dies that are subject to heat checking, especially when water-based coolants are used. Apply to die casting dies used in the aluminum, magnesium and zinc die casting industries. Use also to repair press forging dies and inserts.

Specifications:

➤ Alloy Type	Tungsten Free / 5% Chromium
➤ Hardness	54-57 (Rockwell C) as welded
➤ Preheat	800°F to 900°F
➤ Annealing	1550°F to 1650°F
➤ Hardening	1825°F to 1900°F
➤ Drawing	1000°F to 1200°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 while hot. Cool in still air.

Sizes:

3/32	60-90	AMPS
1/8	80-125	AMPS
5/32	125-175	AMPS

Identification: Fluorescent Yellow End