



**!!!! 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 OH-20**

**Premium Coated Electrode (Oil-Hardening)**

### **Typical Applications:**

For use on oil hardening tools and dies. Types O-1 through O-6. Cold working units such as blanking dies, forming dies, cutting dies, shears and other cutting edges.

### **Specifications:** (Typical Non-Shrink oil hardening tool steel)

➤ Hardness	57-60 (Rockwell C) as welded
➤ Preheat	275°F to 450°F
➤ Forging Temps.	1550°F to 1600°F
➤ Annealing	1425°F to 1450°F
➤ Hardening in Oil	1400°F to 1450°F
➤ Drawing	275°F to 400°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:** Green End