



**!!!! 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.  
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## **Crown PIM-10**

36" Bare TIG Wire (Premium Chrome-Moly-Mold Steel)

### **Typical Applications:**

For repair and buildup on dies, molds and holder blocks used for zinc and plastic injection molds. **Crown PIM-10** is designed to match the wear and polishing characteristics of most injection-mold steels. Deposits are dense, tough and machinable. Used also to make minor repairs on die casting dies, cores and pins. Effective on sulfur and lead-bearing steels where porosity is a problem.

### **Specifications:**

- |                  |  |
|------------------|--|
| ➤ Alloy Type     | AISI P-20  |
| ➤ Hardness       | 34-36 (Rockwell C) as welded.<br>Up to 48-51 (Rockwell C)<br>after heat treatment. |
| ➤ Machinability  | Good   |
| ➤ Heat Treatment | Use P-20 Procedure   |

### **Procedure:**

Prepare area to be welded by grinding out cracks and other defects. Use DC straight polarity. Use argon shielding gas. Preheat and post heat will depend on base metal chemistry, type of weld and amount of deposit.

### **Sizes:**

.035  
.045  
1/16  
3/32  
1/8

**Identification:** Fluorescent Orange End