



!!!! 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 WH-20

Premium Coated Electrode (Water-Hardening)

Typical Applications:

For use on water hardening tools and dies including types W-1 through W-5, cold working shears trimmers, punches, dies, nibblers and similar cutting edges.

Specifications: (Carbon-Vanadium type water hardening tool steel)

- Hardness 56-60 (Rockwell C) as welded
- Preheat Preheat from 275°F to 450°F
- Forging Temps. 1900°F normalizing
1475°F to 1525°F
- Annealing 1375°F to 1425°F
- Hardening (In Brine or Water) 1400°F to 1435°F
- Drawing 250°F to 450°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: Gold End