



!!!! 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 Silicon - Bronze

Cut Length and Spooled Wire
(Mig-Tig & Torch)

Typical Applications:

Crown Silicon Bronze is a copper-silicon-manganese alloy welding rod used to weld copper, brass and dissimilar combinations. Excellent results when used on galvanized and thin sheet metal using Tig or Mig.

Specifications:

AWS A 5.7 & A 5.21

ER CuSi-A	Sn	1.00 max
	Zn	1.00 max
	Fe	0.50 max
	Si	2.8-4.0
	Mn	1.50 max
	Al	0.01 max
	Pb	0.02 max
	Others	0.50 max
	Cu	Remainder

➤ Melting Point	1866°F
➤ Tensile Strength	58,000 PSI
➤ Yield Strength	25,000 PSI
➤ Elongation	54%
➤ Hardness	93 Brinell

Procedure:

Clean joint area thoroughly. Use DC reverse polarity for Mig welding with argon shielding gas. For Tig welding use DC straight polarity or AC with argon shielding gas. For Torch application dip heated rod into **Royal Tiger Flux 3** and proceed to finish flowing alloy into joint until it is completed.

Sizes:

TIG:	MIG:
1/16 x 36"	.023 x 30#
3/32 x 36"	.030 x 30#
1/8 x 36"	.035 x 30#
	.045 x 30#
	1/16 x 30#

Also available in 2# and 8" spools.