



!!! 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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Royal 90

**Bead Forming Aluminum Brazing Alloy
For Tig or Torch**

Typical Applications:

Royal 90 is used for surface brazing of aluminum plate or castings; filling of blow or sand holes; building of worn sections such as gear teeth. **Royal 90** cannot be anodized.

Specifications:

➤ Working Temperature	1050°F to 1100°F
➤ Tensile Strength	Up to 35,000 PSI
➤ Color Match	Excellent
➤ Electrical Conductivity	Good
➤ Corrosion Resistance	Good

Procedure:

Clean joint area. Use **Crown 100 Flux** either as a powder or mixed with water to form paste. Heat with carburizing flame keeping torch in constant motion until flux turns to a clear liquid. Apply alloy. Remove flux residue by quenching and washing in hot water.

Sizes:

1/16
3/32
1/8