



!!! 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 255

Nickel Alloy for Cast Iron (AC-DC)

Typical Applications:

Crown 255 is a machinable nickel-iron electrode for general repair on all cast iron, welding ductile iron, and welding steel to cast iron.

Specifications:

AWS A5.15	Carbon	2.00 max
E NiFe-CI	Silicon	4.00 max
	Manganese	2.50 max
	Copper	2.50 max
	Sulfur	0.03 max
	Nickel	45.0-60.0
	Iron	Balance

➤ Tensile Strength	Up to 65,000 PSI
➤ Yield Strength	Up to 55,000 PSI
➤ Color Match	Good
➤ Elongation in 2"	4-12%
➤ Hardness	200 to 400 Brinell
➤ Deposit	Magnetic

Procedure:

Clean weld area thoroughly. Bevel or use **Chamfer 204** to form a "U" groove. Prepare the groove by grinding or filing it clean. Preheating is not necessary, although warming to 400°F to 500°F will produce a softer weld and minimize stresses on heavier sections. Locate the ends of all cracks. Using **Crown 255**, weld 1-1½" long beads perpendicular to the crack. Begin welding from the center of the crack and weld alternately to the right and left. Select lowest possible amperage. Maintain a medium long arc with electrode tilted slightly in the direction of travel. Short stringer beads or narrow weave beads should be used to prevent excessive heat build up. When breaking the arc always fill the crater and drag rod back over the weld deposit. Stopping to peen often will help relieve stresses. Allow part to cool slowly.

Sizes:

3/32	40-80	AMPS
1/8	60-110	AMPS
5/32	100-140	AMPS
3/16	130-180	AMPS