



!!! 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

Royal 44-30

Premium Nickel-Iron-Manganese Mig Wire

Typical Applications:

Royal 44-30 is excellent for making repairs on all ductile malleable and gray cast irons where highest strength and ductility are required. The addition of manganese provides superior wetting and crack-resistant weldability on even the most difficult cast iron applications. Also best to weld steel to cast iron.

Specifications:

AWS A5.15-90

ER NiFeMn-CI

➤ Tensile Strength	100,000 PSI
➤ Yield Strength	65,000 PSI
➤ Elongation	35%
➤ Color Match	Excellent
➤ Machinability	Excellent

Procedure:

Prepare area to be welded by grinding or cleaning as well as possible. Bevel joint to form a "U" groove. Preheat and postheat treatments are not usually required. However, large complicated sections that are fully restrained will have a better chance of not cracking when preheated. DC reverse polarity with constant voltage is required. Shielding gas should be argon or CO₂ or a 75% Argon/25% CO₂.

Sizes:

.035 x 25#

.045 x 25#

Also available in 2# and 8" spools.