



!!! 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 120FC

**High Strength Nickel Silver Brazing Alloy
For Torch Application**

Typical Applications:

Royal 120FC is excellent for joining both ferrous and non-ferrous metals (except white metals). Because of its thin flowing characteristics, it may be used to replace more expensive silver alloys, where higher temperature does not matter. Also excellent build-up alloy as it work hardens in use. When used to build-up worn or broken gear teeth it will outwear original steel teeth.

Specifications:

AWS A5.8	Tensile Strength	115,000-125,000 PSI
RB CuZn-D	Hardness	90-110 Brinell (as welded) (work hardens up to 220 Brinell)
	Working Temperature	1300°F to 1750°F
	Remelt Temperature	1750° minimum

Procedure:

Clean joint area. For high strength joining, make sure a close fit is maintained. Using **Royal 120FC**, heat joint area to dull-red; melt off small amount of flux and alloy then continue to heat until alloy flows. If bare rod is used it should be heated and dipped in **Royal Tiger Flux**.

Sizes:

3/32 x 18"
1/8 x 18"
3/16 x 18"

Also available in Bare Wire Crown 120

1/16 x 36"
3/32 x 36"
1/8 x 36"
3/16 x 36"
1/4 x 36"