



!!!! 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 Kirkrod

Premium Alloy for Welding Zinc-Based Metals or Brazing Aluminum

Typical Applications:

Royal Kirkrod is the most widely used alloy for welding zinc-based metals, white metal and pot metal. These include carburetors, power mower housings, kirksite dies, power tools, trophies and ornaments, vacuum cleaners, antique car parts, models and patterns. **Royal Kirkrod** is also a very useful self-fluxing brazing alloy for aluminum parts such as boat hulls, propellers, aluminum radiators, doors and furniture. **Royal Kirkrod** can also be used on any galvanized metal. Because the **Royal Kirkrod** is alloyed from pure, virgin metals, deposits are clean and free from slag. Joints made with **Royal Kirkrod** are permanent, non-corrosive and stronger than the parent metal.

Specifications:

➤ Tensile Strength	39,000 PSI
➤ Compressive Strength	93,100 PSI
➤ Hardness	100 Brinell
➤ Elongation in 2"	8.4%
➤ Melting Range	715°F to 735°F

Procedure:

For zinc-based metals: Vee the broken edges to 45°. Clean weld area thoroughly. Heat fracture directly with a neutral flame until the surface oxides of the base metal can be scratched open by jabbing it with the **Royal Kirkrod**. Keep the rod away from the flame as much as possible when starting to weld. Finish by puddling the **Royal Kirkrod** in the base metal. COOL SLOWLY!

For Aluminum: It is critical that the tough aluminum oxides are penetrated by scratching the rod across the heated aluminum surface. Keep the flame in constant motion. COOL SLOWLY!

Sizes: (All sizes are available in 18" and 36" lengths)

1/16
3/32
1/8
5/32
3/16
1/4