

Crown 6

Oxyfuel Gas Welding
(OFW)

Alloy for Cast Iron



"The Royal Line"

CROWN ALLOYS COMPANY

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Cast Iron Welding Rod for Oxyfuel Gas Welding

Typical Applications

Crown 6 is an economical cast iron welding rod for torch. Its modified cast iron composition insures greater flow, superior fusion and tensile strength of the weld deposit. It is an outstanding alloy for cast iron fabrication, repair of foundry defects, building up or filling in new or worn castings. **Crown 6** produces excellent color match, composition and granular structure to gray cast iron. Deposits are as strong as the original casting and are easily machined.

Specifications

- Color Match Excellent (gray cast iron)
- Machinability Excellent
- Hardness 140 to 220 Brinell
- Tensile Strength 20,000 to 38,000 psi

➤ Chemistry

- Carbon 3.10 – 3.70
- Silicon 2.00 – 2.75
- Manganese 0.10 – 0.75
- Iron Balance
- Phosphorus, Sulphur, Nickel, Chromium, Molybdenum 0.25 max. each

Procedure

Clean weld area thoroughly. Bevel, grind or use the **Chamfer 204** to form a 60° to 90° vee groove. When repairing cracks, a hole should be drilled at each end of the crack prior to welding to prevent further propagation of the crack. Preheat to roughly 1,000°F. Use any good cast iron **welding** flux. Select a welding tip one size larger than for steel of the same thickness. Use a neutral flame. The molten metal should be puddled with the flame to eliminate porosity. Dip the heated rod end into the flux. In order to avoid oxidation of the **Crown 6**, be sure that it is always either inside the flame/weld puddle or being dipped in additional flux. Play torch back over the welded area to relieve strain. All remaining slag and oxide must be filed (and not hammered) away from the weld before the casting cools. After welding and filing is finished, cover area with a welding blanket or other insulating material. Cool slowly.

Sizes and Part Numbers

Diameter	Part Numbers	
	1# Package	10# Package
3/16 x 16"	NTCR6/TQ-BP	NTCR6/TQ
1/4 x 16"	NTCR6/TR-BP	NTCR6/TR



!!!! 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 THE NEW 16 SECTION SAFETY DATA SHEET (SDS).

THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS 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 SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.

SEE THE PRODUCT WARNING LABEL AND SDS FOR COMPLETE WARNING INFORMATION.

