

Crown 125FC & Crown 125

Flux Coated and Bare Rod for Gas Brazing (TB)

Copper Based Alloy



"The Royal Line"

CROWN ALLOYS COMPANY

30105 Stephenson Hwy, Madison Heights, MI 48071
(248) 588-3790 (800) 521-7878 www.crownalloys.com

General-Purpose "Low Fuming Bronze" Brazing Alloy for Torch Application

Typical Applications

Crown 125FC and Crown 125 are used for torch applications on cast iron, malleable iron, ductile iron, steel, copper, brass, bronze, nickel, nickel alloys, galvanized steel or dissimilar combinations of the aforementioned metals and alloys. **Crown 125FC and Crown 125** are commonly referred to by their more generic name which is simply: "Brazing Rod".

Specifications

AWS A5.8/A5.8M
RB CuZn-C

- | | |
|-----------------------|-------------------------|
| • Tensile Strength | Up to 65,000 psi |
| • Working Temperature | 1670°F to 1750°F |
| • Color Match | (Brass and Bronze) Good |
| • Machinability | Excellent |

Procedure

Clean joint area. Heavy sections should be beveled for best results. Cast iron surfaces should be "seared" with a strong oxidizing flame and wire brushed to remove surface graphite and impurities. Use a neutral flame. When using the more convenient flux-coated **Crown 125FC**, apply a small amount of flux onto the base metal by melting off the flux coating. When using the non-flux coated or bare **Crown 125**, heat the end of the rod and dip into a jar of flux. Crown Alloys carries two types of flux. The **Crown 125 Flux** is an economical powder flux that can be used on relatively clean base metals. The **Royal Tiger Flux #3** is a premium flux designed for dirty, oil soaked, scaly and rusty base metals. The flux-rod combination should be heated until the flux turns clear and a small amount of the alloy should be melted off. Then continue flowing the **Crown 125FC/Crown 125** into the joint until it is completed.

Sizes and Part Numbers

Product	Diameter	Part Numbers			
		1# Package	5# Package	10# Package	50# Carton
Crown 125FC	1/16 x 18"	CT125F/TL-BP	CT125F/TL	Same as 5# Package	Same as 5# Package
	3/32 x 36"	CT125F/TN-BP	Same as 1# Package	CT125F/TN	
	1/8 x 36"	CT125F/TO-BP		CT125F/TO	
	5/32 x 36"	CT125F/TP-BP		CT125F/TP	
	3/16 x 36"	CT125F/TQ-BP		CT125F/TQ	
	¼ x 36"	CT125F/TR-BP		CT125F/TR	
Crown 125	1/16 x 36"	CT125/TL-BP	Same as 1# Package	CT125/TL-10	CT125/TL
	3/32 x 36"	CT125/TN-BP		CT125/TN-10	CT125/TN
	1/8 x 36"	CT125/TO-BP		CT125/TO-10	CT125/TO
	5/32 x 36"	CT125/TP-BP		CT125/TP-10	CT125/TP
	3/16 x 36"	CT125/TQ-BP		CT125/TQ-10	CT125/TQ
	¼ x 36"	CT125/TR-BP		CT125/TR-10	CT125/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.

