

Crown 2-25-10

Gas Tungsten Arc Welding
(GTAW) TIG Wire

Identifying Color: Silver End

Tool Steel



"The Royal Line"

CROWN ALLOYS COMPANY

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Premium High Strength TIG Alloy for Tool Steel Applications

Typical Applications

Crown 2-25-10 is a high strength alloy that is used for joining and building-up cracked and fractured tools, dies, fixtures and other parts that may require heat treatment. **Crown 2-25-10** will respond to almost all tool steel heat treatments and retain its superior mechanical properties. **Crown 2-25-10** deposits are dense, non-porous, smooth, crack resistant and ductile. **Crown 2-25-10** is impervious to corrosion and heat-scaling up to 1,200°F. It is also used to surface valves, bearings and shafts because of its anti-frictional properties.

Specifications

(Typical)

- Tensile Strength* 118,500 psi
 - Yield Strength* 92,000 psi
 - Elongation* 24%
 - Hardness* 30 – 35 Rockwell C
 - Hardness (as welded) 36 – 40 Rockwell C
- *Typical properties after post weld heat treatment. Heat between 1100°F – 1150°F for one hour.

Procedure

Prepare area to be welded by grinding out cracks and other defects. Remove all contaminants. Preheat and post heat according to base metal chemistry. Use DC straight polarity (DCEN) with argon shielding gas.

Sizes and Part Numbers

Diameter	Part Numbers	
	1# Package	5# Package
1/16 x 36"	TT225/TL-BP	TT225/TL
3/32 x 36"	TT225/TN-BP	TT225/TN
1/8 x 36"	TT225/TO-BP	TT225/TO



!!!! 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.

