

# Crown NT-HW-10 & NT-HW-20

Gas Tungsten Arc Welding  
(GTAW) TIG Alloy

Shielded Metal Arc Welding  
(SMAW) Stick Electrode

Tool Steel



"The Royal Line"

**CROWN** ALLOYS COMPANY

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## Premium Tungsten-Free Hot Work Tool Steel (H-13)

### Typical Applications

**Crown NT-HW-10 (GTAW) and NT-HW-20 (SMAW)** are 5% chromium, tungsten-free hot working tool steel welding alloys that produce dense, fine-grained, heat-treatable deposits which resist abrasion and mild impact in water-cooled hot working service. **Crown NT-HW-10 & NT-HW-20** have a chemistry and mechanical properties that match H-13 hot work tool steels. Some specific applications include hot die work of all kinds, particularly for white metal (aluminum, magnesium and zinc) extrusion dies and die-casting dies, press forging dies and inserts, mandrels and hot shears. **Crown NT-HW-10 & NT-HW-20** weld deposits retain maximum hardness even at continuous operating temperatures of 1000°F.

### Specifications

AISI H-13

Identifying Color:  
Fluorescent Yellow End

- Hardness 54-57 (Rockwell C) as welded.
- Preheat 800°F for all die blocks and other units. All other alloys, preheat according to base metal.
- Annealing 1550°F to 1650°F
- Hardening 1825°F to 1900°F
- Drawing 1000°F to 1200°F
- Heat Treatment Use H-13 procedure

### Procedure

The following procedure must be followed whether using the **NT-HW-10** or the **NT-HW-20**:

Base metal must be clean. Remove all foreign material, fatigued metal & any sharp radii. Preheat according to above chart. Interpass temperature should at least match the preheat temperature. Deposit stringer beads. Peening while hot is advisable. After welding, cool in still air to 300°F to obtain ultimate grain refinement & uniform hardness in the weld deposit.

#### NT-HW-10 Welding Parameters: TIG (GTAW)

Manual Welding – DC straight polarity (DCEN) – Use Argon Shielding Gas

**Tungsten:** Traditional choice is a 2% thoriated tungsten (Red Band), however, the more recent and safer introductions of 2% ceriated tungsten (Orange Band) or 1.5% lanthanated tungsten (Gold Band) have demonstrated superior performance in most applications. Safety note: Thorium is radioactive & may present risks which are negligible under normal conditions of use.

Material Thickness (inches)	Tungsten Diameter	Filler Rod Diameter	Arc Voltage (volts)	Welding Current (amperage)	Gas Flow (cfh)
1/16 to 3/32	1/16	1/16	9 – 14	100 – 160	20
1/8	3/32	1/16	12 – 15	125 – 200	20
3/16	3/32	3/32	12 – 17	130 – 195	25
3/16 to 1/2	1/8	1/8	15 – 20	150 – 300	25

All suggested settings are approximate. Inverter-based welders generally require lower amps. Welds should be tested to comply to your specifications.

#### NT-HW-20 Welding Parameters: Stick Electrode (SMAW)

Welding current can be DC reverse polarity (DCEP) or AC.

However, DCEP ensures the best weldability & penetration.

Electrode Diameter (inches)	Welding Current (amperage)
3/32	50 – 90
1/8	75 – 135
5/32	100 – 180

### Sizes and Part Numbers

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

Electrode Diameter	Part Numbers	
	1# Package	5# Package
3/32	TENTHW/EN-BP	TENTHW/EN
1/8	TENTHW/EO-BP	TENTHW/EO
5/32	TENTHW/EP-BP	TENTHW/EP



**!!!! 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.**

