

Royal 44-30

Gas Metal Arc Welding
(GMAW) MIG Wire

Alloy for Cast Iron

All Position



"The Royal Line"

CROWN ALLOYS COMPANY

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Premium Nickel-Iron-Manganese MIG Wire for Cast Iron

Typical Applications

Royal 44-30 is excellent for making repairs on all ductile and malleable irons. **Royal 44-30** is also useful for the welding of other high-strength nodular and gray cast irons where maximum strength and ductility are required. The addition of manganese provides superior wetting and crack-resistant weldability on even the most difficult cast iron applications. The **Royal 44-30** is also used for surfacing to improve wear resistance or for buildup. It has excellent color match and machinability. Also best for welding steel or stainless steel to cast iron.

Specifications

AWS A5.15-90	Tensile Strength	100,000 psi
ER NiFeMn-CI	Yield Strength	65,000 psi
	Elongation	35%

Procedure

Prepare area to be welded by grinding or cleaning as well as possible. Bevel joint to form a "U" groove. Preheat and post heat treatments are not usually required. However, large complicated sections that are fully restrained will have a better chance of not cracking when preheated.

.035 Wire Diameter (GMAW) - DC reverse polarity (DCEP) with constant voltage is required. * Spray Transfer					
Shielding Gas	Welding Current (amps)	Arc Voltage (volts)	Wire Feed Speed (ipm)	Travel Speed (ipm)	Electrode Extension (inches)
75% Argon 25% CO ₂	130	24	300	15	1/2"
	160	25	400	15	
	180	26	500	15	
	200	27	575	15	
CO ₂	125	24	300	15	1/2"
	155	25	400	15	
	180	26	500	15	
	200	26.8	575	15	
Argon	150	26	300	15	1/2"
	190	27	400	15	
	220	28	500	15 *	
	250	29	575	15 *	

.045 Wire Diameter (GMAW) - DC reverse polarity (DCEP) with constant voltage is required. * Spray Transfer					
Shielding Gas	Welding Current (amps)	Arc Voltage (volts)	Wire Feed Speed (ipm)	Travel Speed (ipm)	Electrode Extension (inches)
75% Argon 25% CO ₂	180	27	250	15	5/8"
	190	28	300	15	
	220	29	350	17	
	240	30	400	20	
	280	32	500	25	
CO ₂	165	26	250	15	5/8"
	180	27	300	15	
	220	28	350	17	
	230	29	400	20	
	270	31	500	25	
Argon	190	27	250	15	5/8"
	220	28	300	15	
	240	29	350	17 *	
	275	30	400	20 *	
	310	32	500	25 *	

Sizes and Part Numbers

Diameter	Part Numbers		
	2 lb (4") Spools	8" Spools	30 lb Spools
.035	RS44/1F	RS44/2F	RS44/3F
.045	RS44/1G	RS44/2G	RS44/3G



!!!! 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.

