

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 50

Description

For all grades of cast iron and cast iron to steel. POSTALLOY 50 is a unique new electrode that uses "state of the art" coating technology to produce maximum welding performance. It should be used for welding all grades of cast iron and cast iron to steel or stainless. POSTALLOY 50 offers the following important benefits.

Maximum Crack Resistivity due to its ideal combination of strength and ductility, and its high tolerance for harmful contaminants, such as sulfur and phosphorus.

Dense Deposits on Dirty, Oil-Soaked Cast Iron - The superior arc-purging action of POSTALLOY 50 penetrates through surface contamination as well as contamination that has literally soaked into the casting to produce a solid porosity-free deposit.

OTHER IMPORTANT BENEFITS OF POSTALLOY 50:

Non-Conductive coating eliminates dangerous side-arcing

Electrodes **resist overheating** - stub loss.

Low amperage minimizes heat rise in the casting

Specifications

Tensile Strength75,000 psi

Hardness200 BHN

Deposits are machinable

Welding Procedures - Use AC or DC Reverse Polarity

Veet out cracks and defective weld metal using POSTALLOY 250 gouging electrode. When using POSTALLOY 50, maintain a short to medium arc length. The arc should be directed on deposited weld metal with the electrode tilted slightly in the direction of travel.

Use stringer beads only - do not weave. Weld beads should be 1" to 3" long (25mm to 75mm), craters to be filled by back whipping, and each pass should be peened immediately upon breaking arc. Remove slag by chipped and brushing. Allow part to cool slowly. Cover with a heat resistant blanket or lime if possible.

Diameter	3/32 (2.5mm)	1/8 (3.2mm)	5/32 (4.0mm)
Current <i>amps</i>	50-70	70-100	100-150

Also available as a bare semi-automatic wire for MIG welding - POSTALLOY 50-SPL