

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 505

Description

Cast Iron electrode for welding and joining various types of cast iron and for welding cast iron to steel. Good for heavy sections. Conforms to AWS 5.15.90 Eni Fe-CI.

Specifications

Tensile Strength.....65,000 psi

Hardness200 BHN

Welding Procedure - Use AC or DC Reverse Polarity.

Veet out cracks and defective weld metal using **POSTALLOY 250** gouging electrode. When using **POSTALLOY 505**, use a short arc length and keep arc directed on deposited metal. Keep the electrode tilted slightly in the direction of travel. It is recommended that a 3/32 (2.5mm) electrode be used for the initial root pass. 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 chipping and brushing. Allow part to cool slowly. Cover with asbestos or lime if possible.

Diameter	3/32 (2.5mm)	1/8 (3.2mm)	5/32 (4.0mm)
Current <i>amps</i>	40-70	65-110	110-140