

POSTLE INDUSTRIES, INC.



P.O. Box 42037 • Cleveland, Ohio 44142

Fax: 216-265-9030 • Phone: 216-265-9000 • Toll Free: 800-321-2978

E-Mail: sparky@postle.com • Web Site: www.postle.com

Data Sheet

POSTALLOY® 51

Description

POSTALLOY 51, for welding all grades of cast iron -gray, malleable, nodular, and ductile offers excellent weldability and highly crack resistant deposits . Especially for thin-walled castings and when maximum machinability is desired after one pass.

Important features of **POSTALLOY 51** are:

Controlled penetration provides sufficient force to penetrate through surface contaminants, but prevents excessive dilution.

Low amperage minimizes the hard brittle zone around the weld.

Outstanding machinability

Excellent wash and fluidity

Very good weld beat tie-in

Deposits are dense and porosity -free.

POSTALLOY 51 will not turn red and overheat, allowing full use of the electrode.

Specifications

Tensile Strength55,000 psi

MachinabilityExcellent

Hardness170 BHN

Welding Procedures - AC or DC Reverse Polarity

Veet out cracks and defective weld metal using **POSTALLOY 250** gouging electrode. When using **POSTALLOY 51**, 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)
Current <i>amps</i>	40-70	65-110

For heliac welding cast iron, use **TIGWELD 53-B**

For MIG welding, use **POSTALLOY 53-SPL**