

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 515

Description

A high nickel alloy with specially formulated coating produces a smooth arc for low temperature welding of cast iron. It is excellent for "cold welding" in all positions. Weld deposits are highly machinable. Conforms to AWS 5.15.90 ENi-CI.

Specifications

Tensile Strength.....55,000 psi

Hardness170 BHN

Welding Procedure - Use AC or DC Reverse Polarity.

Veet out cracks and defective weld metal using **POSTALLOY 250** gouging electrode. When using **POSTALLOY 515**, 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