

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 53-SPL

Description

POSTALLOY 53-SPL, a solid, gas-shielded welding wire, is designed for joining and build-up on various types of cast iron, such as ductile, nodular, gray, and Ni-resist. Also for welding cast iron and cast iron to steel or stainless steel.

The unique chemistry of **POSTALLOY 53-SPL** provides weld deposits that are fully machinable. Under normal circumstances, if dilution is kept to a minimum, there is no undercutting and weld deposits can be machined through the fusion zone, even with high speed steel tooling.

Weld Deposit Properties:

Tensile Strength.....60,000 psi
Hardness.....100 -150BHN
Machinability.....Excellent

Welding Parameters: Use DC Reverse Polarity.

Gas Coverage: While both Argon and Argon /CO₂ can be used as a gas cover, pure Argon will help this alloy to wet out better on cast iron and produce much better welding characteristics. Typical volts and amps are 18 to 22 volts and 140 to 170 amps.

POSTALLOY 53-SPL should be applied in stringer beads with only a slight side to side oscillating motion. All craters should be back-filled. Optimum bead contour is slightly convex. Peening will help to relieve stresses.

When welding cast iron preheat will improve machinability and reduce stress caused by welding.

Gray, nodular and ductile: 400° - 500°F(200° - 260°C)
Ni-resist and other alloyed types: 800° - 1000°F(425° - 540°C)

Packaging

Diameter	.045“(1.2mm)
5 Lb. Spools	Standard
25 Lb. Coils	Standard