

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY[®] 95 (AC) POSTALLOY[®] 950 (DC Rev)

Description

Joining and overlaying copper alloys, steel and cast iron. Ideal for dissimilar combinations, such as steel to copper. Excellent weldability. Provides a good combination of strength and ductility.

The arc is smooth with a consistent burn-off rate. It may be used out-of-position. The core wire of **POSTALLOY 95 and 950** melts well below the melting point of iron base alloys, such as steel and cast iron. This makes it ideal for applications where the use of standard steel or cast iron electrodes would be damaging to the base metal.

Specifications

Tensile Strength.....	60,000 psi
Elongation	40%
Hardness	100 BHN
Machinability.....	Excellent

Applications

Bearing surfaces	Pumps
Bushings	Valve parts
Impellers	Gear wheels
Bushings	Corroded cast iron parts
Propellers	Galvanized steel

Welding Procedure - Use 95 with AC and 950 with DC Reverse Polarity

Clean weld area of greases and contaminants. Remove surface oxides by filing, sanding or grinding. Preheat copper 1000°F (538°C), brass 600°F (315°C), cast iron 400°F (204°C). Bevel heavy sections 45°. Hold a close arc using stringer beads or a slight weave. Allow to cool and remove slag.

Diameter	1/8 (3.2mm)
Current <i>amps</i>	80-130