

Cast-Alloy™ 60



DESCRIPTION:

Cast-Alloy 60 is an AWS Class A5.15 ENi-CI electrode. Because of its chemistry (approximately 50% iron and 50% nickel), the Cast-Alloy 60 can offer several advantages over conventional “straight” nickel electrodes. Among its benefits are stronger and more ductile deposits, better hot crack resistance, lower coefficient of thermal expansion and lower cost. Cast-Alloy can run on either DCEP or AC power.

OPERATIONAL CHARACTERISTICS:

Cast-Alloy 60 deposits sound weld metal on good quality castings. Bonding to both base metal and adjacent beads is complete. Spatter level is low and slag is easily removed.

TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis

Carbon (C)	1.30
Manganese (Mn)	0.50
Silicon (Si)	0.60
Iron (Fe)	48.00
Nickel (Ni)	49.00

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

Tensile Strength	70,000 psi (483 MPa)
Yield Strength	52,000 psi (359 MPa)
Elongation % in 2"	9.5

RECOMMENDED OPERATING PARAMETERS*:

Diameter		Type of Power	Optimum Amps
Inches	mm		
3/32	2.4	DCEP or AC	65 - 80
1/8	3.2	DCEP or AC	90 - 105
5/32	4.0	DCEP or AC	120 - 140

AVAILABLE DIAMETERS AND PACKAGES*:

Diameter		Length		10-lb. can
Inches	mm	Inches	mm	
3/32	2.4	12	305	S500631-036
1/8	3.2	14	355	S500644-033
5/32	4.0	14	355	S500651-032

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TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, “Safety in Welding and Cutting,” published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

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Revision Date: 170526 (Replaces 140829)
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