

Cast-Alloy™



DESCRIPTION:

Cast-Alloy is an AWS Class A5.15 ENi-CI electrode. This “straight” nickel electrode excels in low-stress welding applications on light and medium weight castings and where maximum machinability is desired. Either DCEP or AC power can be used with this electrode.

OPERATIONAL CHARACTERISTICS:

Cast-Alloy 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)	1.10
Manganese (Mn)	0.40
Silicon (Si)	2.70
Copper (Cu)	1.40
Iron (Fe)	5.50
Nickel (Ni)	89.00

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

Tensile Strength	40,000 psi (276 MPa)
Yield Strength	38,000 psi (262 MPa)
Elongation % in 2"	4.5

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	S500531-036
1/8	3.2	14	355	S500544-032
5/32	4.0	14	355	S500551-032

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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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