Cast-Alloy™ T-60

CAST-IRON WIRE ELECTRODE

REPLACES CI-001 *230-C, INDEX: 990129*

Description:

Cast-Alloy T-60 is a tubular core wire electrode version of the Cast-Alloy 60. It is also classed as an AWS A5.15 ENiFe-CI electrode. Cast-Alloy T-60 possesses all of the characteristics of the Cast-Alloy 60; in addition, it has higher elongation, lower cost, and better operator appeal than typical ENiFe-CI electrodes. DCEP is recommended.

Operational Characteristics:

Cast-Alloy T-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)	0.20
Silicon (Si)	0.80
Iron (Fe)	51.00
Nickel (Ni)	46.00

Typical Mechanical Properties (As Welded):*

Tensile Strength	71,000 psi (490 MPa)
Yield Strength	46,000 psi (317 MPa)
Elongation in 2"	18%

Recommended Operating Parameters:

Diameter			Optimum
inches	mm	Type of Power	Amps
3/32	2.4	DCEP	65 – 80
1/8	3.2	DCEP	90 – 105
5/32	4.0	DCEP	120 – 140
3/16	4.8	DCEP	140 – 160

Available Diameters and Packages:

Diameter		Length		10-lb.
inches	mm	inches	mm	can
1/8	3.2	14	355	S501644-033
5/32	4.0	14	355	S501651-033

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