

## POSTALLOY® 505



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### Description

Cast Iron electrode for welding and joining various types of cast iron and for welding cast iron to steel. Good for heavy sections. Conforms to AWS 5.15 ENi Fe-CI.

### Specifications

Product Type: Cast Iron electrode

#### Weld Deposit Properties

Tensile Strength	450 MPa
Hardness	200 BHN

### POSTALLOY® 505 Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
2.5mm	40-70
3.2mm	65-110

#### Welding Procedure:

When using POSTALLOY 505, use a short arc length and keep arc directed on deposited metal. Keep the electrode tilted slightly in the direction of travel. It is recommended that a 2.5mm electrode be used for the initial root pass. Use stringer beads only - do not weave. Weld beads should be 25 to 75mm long, craters to be filled by back whipping, and each pass should be peened immediately upon breaking arc. Remove slag by chipping and brushing. Allow part too cool slowly. Cover with asbestos or lime if possible.

### Packaging Options

Diameter	Standard Packaging
2.5mm	Resealable Plastic Box
3.2mm	Resealable Plastic Box

Diam.	4.54 kg Pack
2.5mm	PHF50525
3.2mm	PHF50532

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