

AWS CLASSIFICATION

AWS A5.15-90, ENiFe-CI-A

DESCRIPTION

Stoody Castweld 55 is used on worn cast iron parts requiring build up or joining but not needing tight dimensional control or machining. Castweld 55 has good tolerance for the high phosphorus often found in cast iron to dissimilar metals.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	3/32 (2.4)	1/8 (3.2)
Current, Amp. DCRP	40 – 80	70 – 110
Position	Flat	Flat
Length	9"	14"

Diameter, In. (mm)	5/32 (4.0)
Current, Amp. DCRP	100 – 140
Position	Flat
Length	14"

TYPICAL DEPOSIT CHARACTERISTICS

Deposit Layers	Unlimited
Machinable	Poor

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
3/32" (2.4mm)	5# Vac Pak	11375000
1/8" (3.2mm)	10# Vac Pak	11369500
5/32" (4.0mm)	10# Vac Pak	11369400

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	1.3
Manganese	0.6
Nickel	49.0
Silicon	0.8
Iron	Balance

TYPICAL APPLICATIONS

Typical applications include:

- Joining or build up of cast iron parts
- Engine blocks
- Pump housings
- Assorted castings

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