

DESCRIPTION

Stoody Castweld 57 consistently produces weld deposits which exceed the physical properties of standard 50Ni/50Fe electrodes (ENiFe-CI or ENiFe-CIA). These have typical weld deposit impact strengths of 1 to 9 foot pounds. Castweld 57 can achieve impact strengths of 10 to 15 foot pounds. Castweld 57 is used on worn cast iron parts requiring build up or joining but not needing tight dimensional control or machining. Castweld 57 has good tolerance for the high phosphorus often found in cast iron to dissimilar metals.

TYPICAL APPLICATIONS

Typical applications include:

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

TYPICAL DEPOSIT CHARACTERISTICS

Deposit Layers	Unlimited
Machinability	Poor
Tensile Strength (ksi)	62
Yield Strength (ksi)	51
Elongation (%)	7
Charpy Impact Strength (ft-lbs @ room temperature)	12.5

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	3/16 (4.8)	5/32 (4.0)
Current, Amp. DCRP	120 – 170	100 – 140
Position	Flat	Flat
Length	14"	14"
Diameter, In. (mm)	1/8 (3.2)	
Current, Amp. DCRP	70 – 110	
Position	Flat	
Length	14"	

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	1.1
Manganese	5.0
Nickel	54.0
Silicon	0.4
Iron	Balance

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
3/16" (4.8mm)	10# Vac Pak	11951100
5/32" (4.0mm)	10# Vac Pak	11956800
1/8" (3.2mm)	10# Vac Pak	11956900

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