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Postalloy® TIGWELD 53-B is designed for repair, build-up and overlaying various types of cast iron, such as ductile, nodular, gray and Ni-resist. Postalloy® TIGWELD 53-B is deposited by a low temperature method called TIG BRAZE. By using a combination of the TIG torch for the heat source and the principles of brazing, a strong diffusion bond is produced. When deposited in this fashion, dilution and overall heat input are kept to an absolute minimum. The tendency for weld metal porosity and the hardness in the fusion zone are greatly reduced.

- * Superior weld-metal to base -metal bonding
- * High weld metal ductility and crack resistance
- * Excellent Machinability
- * Good color match

Specifications

Product Type

TIG. Also available as a semi-automatic wire - Postalloy® 53-SPL
Identification: Yellow Tip Color

Weld Deposit Properties

Excellent machinability
High weld metal ductility and crack resistance

Applications

Foundry Defects
Rebuilding worn cast iron parts such as patterns and molds
Repairing fractures and cracks

Postalloy® TIGWELD 53-B Welding Parameters

Current: Current:

TIG

- 1/16" (1.6mm)
- 3/32" (2.4mm)

Welding Procedure

Use Argon Gas Shielding- DC Straight Polarity. Use Postalloy® 2802 2% Thoriated Tungsten Electrodes. Remove contaminants and any defective metal. Amperage is determined by base metal thickness. preheating to approximately 400°F (204°C) is beneficial in keeping welding stresses to a minimum and "Soaking in Heat" for several hours prior to welding will help remove much of the grease and oil that has soaked into the base metal. During welding, keep the filler rod between the tungsten arc and base metal. This will keep heat input to a minimum and will produce a "weld braze" deposit. Allow part to cool slowly. Peening will help to reduce cooling starins.

