

CASTWELD



FAMILY OF CAST IRON WELDING PRODUCTS

For over 75 years, the STOODY name has meant quality and state-of-the-art performance in welding alloys...and, the STOODY Castweld family of products is no exception. Specifically designed for the overlay, build-up and joining of weldable cast irons, Castweld products exhibit the superior arc characteristics and high operator appeal that welders have come to expect from STOODY.

When you combine Castweld's high quality and performance with the range of products available in the Castweld line, you are sure to find just the right product for your cast iron welding needs.

Try STOODY's Castweld products in your next cast iron welding project and you will see why welders prefer STOODY. Ask your STOODY distributor or call STOODY Customer Service Department for a free sample of Castweld.

STOODY
A THERMADYNE® Company

CASTWELD 55			
Diameter	3/32	1/8	5/32
Welding Position	All	All	Flat
Amperage	40 - 80	70 - 110	100 - 140

CASTWELD 55 (AWS A 5.15) Class ENiFe-CI-A

A solid core electrode designed for build-up or joining of weldable cast irons. This is **STOODY's** highest strength nickel/iron electrode and is the best choice for welding thick sections and high phosphorus or dirty castings. It is also your best choice for joining cast iron to steel. As a rule, Castweld is considered non-machineable but can be ground to finish.

CASTWELD 99 (AWS A 5.15) Class ENiCl

A "High Nickel" type electrode, Castweld 99 is typically used where easily machined deposits are required. It is also useful in repairing cracks and defects in castings. Castweld 99 is suitable for thin or thick sections and can be used as final weld layers to achieve machinability.

CASTWELD 99			
Diameter	3/32	1/8	5/32
Welding Position	All	All	Flat
Amperage	40 - 80	70 - 110	100 - 140

CASTWELD Ni 55-G

Diameter	1/16	3/32
Welding Position	Flat	Flat
Amperage	200 - 250	280 - 380
Voltage	24 - 27	24 - 27
Wire Extension	5/8" - 3/4"	3/4" - 1

CASTWELD 55-G

All the attributes of Castweld 55 in a CO2 gas-shielded wire. Allows higher deposition and weld efficiencies to be achieved when compared to stick electrodes. It is an excellent choice for large jobs, as well as repairing or joining heavier sections of cast iron.

CASTWELD 55-O

Alloy cored, open-arc (no shield gas needed) welding wire with high tensile strength for joining and repair of heavy sections. Its open-arc design makes it an outstanding choice for field welding of heavy pieces where conditions make it impractical to protect the work area from drafts or wind.

CASTWELD Ni 55-O

Diameter	1/16	3/32
Welding Position	Flat	Flat
Amperage	200 - 250	280 - 380
Voltage	24 - 27	24 - 27
Wire Extension	5/8" - 3/4"	3/4" - 1



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