

Postle Industries • Cleveland, OH USA • Telephone: 216-265-9000 • Fax: 216-265-9030

## Description Superior Cast Iron Electrode

POSTALLOY® Nico-Tek is a superior tubular cast iron electrode using state of the art manufacturing and coating technology to produce a welding electrode that is suitable for joining and surfacing various grades of cast iron and cast iron to steel. Ideal for heavy weldments and filling in deep cavities. Nico-Tek produces a weld deposit with lower weld shrinkage stress which reduces the possibility of weld or heat-affected zone cracking. Nico-Tek has excellent arc-gouging action that penetrates through surface contamination. The easily controlled weld metal results in spatter free weld deposits with no undercutting.

1/4" diameter tubular electrode operates at 90 to 120 amps... the same as a standard 1/8" diameter flux coated electrode.

Tubular construction allows it to be used at lower amperage.

Tubular electrodes resist overheating.

Creates dense deposits on dirty, oil soaked cast iron.

Low amperage prevents heat rise in casting.

Weld layers can be easily filled or machined.

## Specifications

### Product Type

Flux-coated Tubular Electrode

### Weld Deposit Properties

Weld deposits can be machined.

## Applications

Castings, Cast Iron, Valves, Machine Parts

## POSTALLOY® Nico-Tek Welding Parameters

Current: AC or DC Reverse Polarity

| Diameter     | Amps   |
|--------------|--------|
| 1/4" (6.0mm) | 90-120 |

### Welding Procedure

Use a short arc length and keep arc directed on deposited metal. Keep the electrode tilted slightly in the direction of the travel. Remove slag by chipping and brushing.

## Packaging Options

| Diameter     | Standard Packaging     |
|--------------|------------------------|
| 1/4" (6.0mm) | Resealable Plastic Box |

