



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

RCI Modified ALLOY

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

Washington Alloy RCI Mod. has properly balanced and controlled levels of high silicon, low manganese and trace amounts of phosphorus and sulfur. This composition insures greater flow with good fusion and tensile strength of the weld deposit. Machinable weld deposits with color match, composition and granular structure to gray cast iron. This alloy is a high-quality gray iron oxyacetylene welding rod, designed for gas welding of cast iron, general fabrication or building up new or worn surfaces on castings. It is excellent for cast iron fabrication, repair of foundry defects, filling in or building up new or worn castings. Properly made welds will be as strong as the original casting. Use our cast iron welding flux with a slightly reducing flame to control oxides and as with all cast iron allow parts to cool slowly.

NOMINAL CHEMICAL COMPOSITION, Weight Percent:

Carbon	3.10 - 3.70
Manganese	0.45 - 0.75
Silicon	2.00 - 2.75
Phosphorus, Sulphur, Nickel, Chromium & Molybdenum	0.25 max each

PHYSICAL DATA: Typical

Color	Gray Cast Iron
Hardness as welded	140-220 Brinell
Tensile Strength	20-38,000

AVAILABLE SIZES:

TU RCI = 3/16", 1/4"

SPECIFICATIONS: Washington Alloy Internal (Modified AWS A5.15 RCI)

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GULF COAST
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