

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 206HD

Description

POSTALLOY 206HD is a high chromium, nickel, moly alloy electrode that produces deposits with excellent strength and elongation, combined with a high degree of toughness. Weld deposits work-harden in service and provide outstanding impact resistance. The austenitic structure of the weld deposit provides very good corrosion resistance. It's versatility allows it to be used for joining, as well as a cushion layer prior to hardfacing with a harder, more wear resistant alloy.

Use on carbon and alloy steels, stainless and manganese steels and joining dissimilar combinations.

Specifications

| | |
|------------------------------|-------------|
| Tensile Strength | 100,000 psi |
| Yield Strength..... | 78,000 psi |
| Elongation | 25% |
| Hardness as deposited | 100-150 Rb |
| Work-hardened..... | 30-35 Rc |
| Deposits cannot be flame-cut | |
| Deposits are machinable | |

Applications

| | |
|--------------------------------------|-------------------------------------|
| Rebuilding under carriage components | Impactors |
| Sprockets | Weld in wear plate |
| Gear teeth | Cushion layer for hardfacing alloys |
| Sheaves | |

Welding Procedure: AC or DC Reverse.

Clean weld area. Use **POSTALLOY 250** to remove damaged metal. Do not preheat manganese steels. Maintain a short to medium arc. Direct the arc on deposited weld metal depositing 3 to 4 inches at a time (75mm-100mm). Interpass temperatures should be kept low on manganese steel by back-stepping and skip-welding. Skip welding is advisable on large parts. Peening while hot helps shape the deposit and reduce stress. Cool slowly.

| | | | |
|-------------------|--------|---------|---------|
| DIAMETER: | 1/8" | 5/32" | 3/16" |
| AMPERAGES: | 90-135 | 125-160 | 150-200 |

Also available as a semi-automatic wire - **POSTALLOY 2866-FCO**.