

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY[®] 214

Description

POSTALLOY 214 is a high chromium carbide hardfacing electrode for high abrasion and mild impact applications. Deposits take on a high polish, producing excellent frictional and sliding abrasion resistance. Use on carbon and alloy steels, stainless steels and cast iron.

Heat and Corrosion Resistant - Corrosion resistance is equal to straight chromium steels and it retains its hardness up to 1000°F(538°C)..

POSTALLOY 214 offers good out-of-position welding characteristics on either AC or DC. Fast deposition rate and easy slag removal. It produces minimum dilution for high first pass hardness and deposits are extremely smooth - almost ripple free.

Specifications

Hardness.....up to 60 Rc
Deposit Thickness2 - 3 passes
Relief checks readily to prevent stress build-up.
Cannot be flame cut.

Applications

Farm implements	Dust fan blades
Asphalt and concrete mixer paddles	Crushing and pulverizing tools
Road ripper teeth	Grader blades
Ditch digger teeth	Muller tires
Conveyor screws	Feed screws
Dredge pump impellers	

Welding Procedure: AC or DC Reverse or Straight

Due to lower dilution, DC straight polarity will produce a higher first pass hardness and is also ideal for thin sections. Remove all damaged or fatigued metal. Preheating is generally not required. However, for high carbon or alloy steels and cast iron, a preheat of approximately 400°F (204°C) is recommended. Maintain a short to medium arc using a weave technique. Remove slag.

DIAMETER::	3/32 (2.5mm)	1/8 (3.2mm)	5/32 (4.0mm)	3/16 (4.8mm)
AMPERAGES:	70-110	90-130	100-150	140-190

Also available as a semi-automatic wire - **Postalloy DuraChrome-G**(metal-cored, gas-shielded) **2832-SPL**(metal-cored, open-arc), or **2834-SPL**(metal-cored, open-arc).