

# POSTLE INDUSTRIES, INC.



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## Data Sheet

# POSTALLOY® 219HD

### Description

When protection with tungsten carbide is needed, **POSTALLOY 219HD** is an ideal choice. Weld deposits contain tungsten carbide in a chromium rich matrix for added wear and corrosion protection.

**POSTALLOY 219HD** hardfacing electrodes, available in 1/4"(6.0mm) diameter, are a unique concept in hardfacing technology. They are tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes. Due to its unique tubular design, **POSTALLOY 219HD** offers very smooth operational characteristics. Other outstanding features are:

- Easy out-of-position weldability with the 1/4" diameter.
- Excellent AC or DC operation, even on a "buzz box".
- High metal recovery - no slag to chip. **POSTALLOY 219HD** is over 90% efficient..
- Low amperage - 1/4"(6.0mm) from 80 amps..
- High deposition rates - up to 3 times faster than ordinary electrodes.
- Moisture resistant coating, even under severe weather or high humidity

### Specifications

- Hardness: .....64 - 68 Rc
- Deposit thickness: .....2 layers
- Relief checks readily to prevent stress build-up.
- Cannot be flame cut.

### Applications

- |                          |                                     |
|--------------------------|-------------------------------------|
| Auger points             | Debarking hammers                   |
| Cutter teeth             | Anvil knives                        |
| Flights                  | Tamping tools                       |
| Pilot bits               | Sand slinger cups and impeller tips |
| Mixer paddles and blades | Dragline chains                     |
| Screw conveyors          | Bucket pin ends                     |
| Shredder knives          | Ditcher teeth                       |
| Muller plows             | Dredge bucket lips                  |
| Fan blades               | Dredge teeth                        |
| Churn drills             | Fly ash conveyors                   |
| Cable tool core heads    |                                     |

### Welding Procedure - AC or DC Polarity.

Remove old hardfacing and any fatigued base metal. **Postalloy 250** gouging electrode is useful for this purpose. Preheat from 200° to 400°F(93° - 204°C) is recommended for steels with a carbon content of .25 to .45. Steels with a higher carbon level should be preheated from 400° to 700°F(204° - 371°C). Do not preheat austenitic manganese steel. Use a minimum arc length equal to about the diameter of the electrode. Hold the electrode at 90° to the work surface for proper application. Do not apply more than two layers. On manganese or hardened steel, an intermediate or cushion layer of **POSTALLOY 207** is recommended.

- DIAMETER:** 1/4" (6.0mm)
- AMPERAGE:** 80 - 130