

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 21

Description

POSTALLOY 21 is a "self-hardening" wear resistant overlay engineered for abrasion and abrasion combined with medium impact. The alloy chemistry provides good resistance to spalling and chipping while the special low hydrogen coating minimizes dilution and helps to eliminate underbead cracking.

Use on carbon and low alloy steels, It can be used out-of-position and can be used with all types of AC or DC equipment.

Specifications

Weld Deposit Properties:

Hardness as Deposited56-60 Rc
Deposit Thickness2-3 Passes
Deposits are non-machinable

Applications

Excavator parts	Bucket lips and teeth
Tamping tools	Dozer and grader blades
Screw conveyors	Grader end bits
Elevator bucket lips	Post hole augers
Muller tires	Wear areas on clamshell
Mining	Dragline and shovel buckets
Earthmoving and construction equipment	

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:	1/8	5/32	3/16
AMPERAGES:	110-130	130-160	150-250

Also available as a semi-automatic wire - **Postalloy 2898-SPL**(metal-cored) or **2898-FCO**(flux-cored).