

POSTLE INDUSTRIES, INC.

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Data Sheet

POSTALLOY[®] 250

Description

POSTALLOY 250, for gouging and grooving all metals, removes unwanted metal with standard AC or DC power sources. Unsurpassed For stainless steel or cast iron. Does not require supplementary gas, compressed air or special electrode holders. **POSTALLOY 250** produces an intense, highly concentrated blowing action which virtually blasts molten metal and slag out of its path. Leaves a clean, scale-free, carbon-free surface which requires no additional preparation.

The coating constituents in **POSTALLOY 250** are formulated to provide a conductive slag during fusion. This imparts self-starting characteristics to the electrode. This feature enables the welder to pre-place the rod in the exact spot where the metal is to be removed without instantaneous arcing.

Applications

- Veeing out cracks prior to welding
- Gouging out old or defective weld metal
- Removing flash and risers
- Removing unwanted metal before machining

Welding Procedures - Use AC or DC Straight Polarity

Point electrode in direction of travel. Angle of electrode should be almost parallel to weld or crack. Strike arc. Push electrode along quickly for a shallow groove, more slowly or with a weaving motion for deeper groove.

Diameter	3/32 (2.5mm)	1/8 (3.2mm)	5/32 (4.0mm)	3/16 (4.8mm)
Current <i>amps</i>	150-250	250-400	300-450	350-500