

# POSTLE INDUSTRIES, INC.



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Data Sheet

## POSTALLOY® 2808-FCG

### Description

Postalloy 2808-FCG is a flux-cored, gas-shielded nickel base alloy with an excellent combination of toughness, resistance to thermal shock, frictional metal-to-metal wear and heat resistance. Machinable deposits are especially resistant to deformation from repeated impact at high temperatures. Weld deposits work-harden and age-harden in service, providing good wear resistance and will not chip, crack or spall.

### Specifications

**Wire Type:** Flux-cored, gas-shielded.

**Weld Deposit Properties:**

Hardness as deposited .....15 - 20 Rc  
Work-hardened.....up to 45 Rc  
Heat Resistance up to 1500°F(816°C)  
Deposits are machinable

### Applications

Overlying forging dies	Hot metal handling equipment
Hot forming dies	Hot shear blades
Ingot tong bits	

**Welding Parameters** - Use DC Reverse Polarity with a globular type metal transfer. Gas Coverage - 75% Argon / 25% CO<sub>2</sub>

Diameter	.045" (1.2mm)	1/16" (1.6mm)
Current <i>amps</i>	120-200	150-250
Voltage (DCRP) <i>volts</i>	23-27	24-28
Stickout <i>inch (mm)</i>	1/2"-5/8"(12-15mm)	3/4"(18mm)
Gas Flow <i>cfh (l/hr)</i>	40-45	40-45

### Packaging

Diameter	.045" (1.2mm)	1/16" (1.6mm)
5 Lb. Spools	Standard	Standard
25 Lb. Spools	Standard	Standard