

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 281-SPL

Description

POSTALLOY 281-SPL is a unique abrasion resistant chromium carbide open-arc overlay. It produces weld deposits that are fully machinable and crack-free, and is designed for applications requiring a heavy build-up. In addition, it offers extremely good heat, corrosion and metal-to-metal wear resistance.

Specifications

Wire Type: Metal-cored, open-arc or gas-shielded.
Deposits are slag-free.

Weld Deposit Properties:

Hardness: 38 - 42 Rc
Excellent oxidation resistance up to 1100°F(591°C)
Deposit Thickness: Unlimited. Preheat may be necessary for certain low alloy and high carbon steels.
Deposits cannot be flame cut

Applications

Augers
Screws,
Centrifugal pump casings
Dredge pump journals

Welding Parameters - DC Reverse or Straight Polarity

Diameter	.045" (1.2mm)	1/16" (1.6mm)
Current <i>amps</i>	100-225	160-300
Voltage (DCRP) <i>volts</i>	15-26	20-28
Stickout <i>inch (mm)</i>	3/4"-1" (18-25mm)	1"-1½" (25-35mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA

While both sizes of Postalloy 281-SPL will easily operate with or without a gas cover, you may find applications for which you prefer a shielding gas. If a gas cover is used, Argon/CO₂ or 100% CO₂ is recommended. This will cause amperages to go up by about 10% and the stick-out should be shortened.

When welding out of position, use the lower range of amperages and voltages. In addition, a gas cover may be useful, especially when using a constant current power source and voltage sensing feeder.

Packaging

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