

# POSTLE INDUSTRIES, INC.



P.O. Box 42037 • Cleveland, Ohio 44142  
Fax: 216-265-9030 • Phone: 216-265-9000 • Toll Free: 800-321-2978  
E-Mail: sparky@postle.com • Web Site: www.postle.com

Data Sheet

## POSTALLOY® 2826 SPL

### Description

A martensitic tool steel type alloy with numerous tightly packed carbides for excellent abrasion resistance under high impact. Deposits are smooth and free of any slag. One layer deposits exhibit wear characteristics that you would expect from chromium carbide hardfacing products. An excellent choice for applications requiring crack free deposits with good wear characteristics.

### Specifications

- Wire Type:** Metal-cored, gas-shielded  
Deposits are slag-free
- Weld Deposit Properties:**  
Average Hardness: 55-58 Rc  
Maximum overlay: Unlimited with proper procedures  
Non-Machinable: Must be ground

### Welding Parameters

Diameter	1/16" (1.6mm)
Polarity	Reverse(DCEP)
Gas	98% Argon/2% Oxygen
Gas Flow	30 - 35 CFH
Current <i>amps</i>	160-300 ( <i>Typical 280A</i> )
Voltage <i>volts</i>	26-32 ( <i>Typical 30V</i> )
Stickout <i>inch (mm)</i>	3/4"-1-1/4" (19-32mm)
Preheat	350/450°F (165/232°C)
Maximum Interpass	700 °F (370°C)
Post Welding	Slow Cool to Room Temp

### Packaging

<b>Diameter</b>	<b>1/16"(1.6mm)</b>
25 lb. Spools	Available
50 lb. Spools	Available