

# POSTLE INDUSTRIES, INC.



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Data Sheet

## POSTALLOY® 2828-FCO

### Description

Postalloy 2828-FCO is a self shielded, flux cored wire that deposits a martensitic alloy with a high volume of finely dispersed Titanium Carbides (TiC). It has excellent abrasion resistance under low and high stress conditions and retains hardness at high temperatures. Crack free deposits are possible with proper procedures.

### Specifications

**Wire Type:** Flux cored, open arc  
Deposits contain slight slag cover but does not require removal between passes.

**Weld Deposit Properties:**

Average Hardness: 48 - 53 Rc  
Good Hot-hardness: up to 1100° F(595°C)  
Non-Machinable: must be ground  
Cannot be flame cut

### Applications

Hot Shear Blades	Dozer Blades
Hammers	Bucket Teeth
Farm Implements	Augers

### Welding Parameters - Use DC Reverse Polarity (DCEP)

	<b>.045(1.2mm)</b>	<b>1/16(1.6mm)</b>	<b>7/64(2.8mm)</b>
Amps	120-150	180-200	300-350
Volts	26-30	26-30	26-30
Stick-out	1"(25mm)	1"-1¼"(25-30mm)	1"-1½"(25-40mm)

Transfer is globular and deposits contain a thin tenacious slag. Out of position welding is limited to horizontal stringers. Preheats and Interpass temperatures should be 500°F(260°C) minimum.

### Packaging

<b>Diameter</b>	<b>.045"(1.2mm)</b>	<b>1/16"(1.6mm)</b>	<b>7/64"(2.8mm)</b>
25 lb. Spools	Standard	Standard	NA
60 lb. Coils	Available	Available	Standard
110 and 220 lb Drums	NA	NA	Available

Postalloy® equivalent electrode is not available.