

# POSTLE INDUSTRIES, INC.



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## Data Sheet

# POSTALLOY® 2839-SPL

### Description

Postalloy® 2839-SPL is a gas shielded iron base high carbon tool steel cored wire that is capable of producing single and multiple layer weld deposits comprised of a large volume of extremely hard multi-Carbides surrounded by a Martensitic matrix. Deposits perform well under low and high stress abrasion and show dramatic improvements over traditional Chromium Carbide products. It may be used on carbon, low alloy, and manganese steels. Unlike Chromium Carbide Alloys, 2839-SPL deposits are heat treatable, allowing for tougher weld metal for applications that encounter moderate impact.

Microstructure .....	Multiple Carbides in Martensitic Matrix
Hardness.....	58-61Rc As Welded - Work Hardens Slightly
Machineability .....	Poor. Grinding Only
Deposit Thickness .....	Unlimited with proper procedures
Check Cracking.....	None with proper procedures
Shielding Gas .....	Argon 2% Oxygen, Argon 25% Co <sub>2</sub>
Welding Flux.....	NA

### Applications

Mixer Paddles	Dies	Cutting Blades
Sizing Screens	Chutes & Liners	Concrete Pump Parts
Klinker Rolls	Farm Implements	Pipes & Elbows
Conveyor Screws	Wear Pads & Plates	Glass Recycling

### Welding Parameters

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</i>	30-35	30-35

Contact Postle Technical Staff for WELDING PROCEDURES AND HEAT TREATMENT

### Packaging

Diameter	.045" (1.2mm)	1/16" (1.6mm)
25 Lb., Spools	Standard	Standard
55 Lb. Coils.	NA	Available
110, 250 Lb. Drums	Available	Available

Other packaging available upon Request