

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 284-SPL

Description

POSTALLOY 284-SPL is a multi-component open-arc hardfacing overlay containing a large volume of chromium carbides and extremely hard chromium borides uniformly dispersed throughout the deposit. It is recommended for applications involving severe abrasion, abrasion coupled with mild impact or when abrasion up to 1000°F(538°C) prevails.

Specifications

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

Weld Deposit Properties

Hardness: 62 - 65 Rc
Excellent oxidation resistance up to 1000°F(538°C)
Deposit thickness - 1 - 2 layers
Cannot be flame-cut
Surface checks readily to relieve stresses

Applications

Sinter breakers	Classifier flights	Cement chutes
Grizzly bars	Buckets and lips	Pug mill paddles
Augers and conveyor screws	Wear plates	Die rings
Exhaust fans	Bulldozer blades	Feeder blades
Coke pusher shoes	coal feeder screws	Arbors
Coke chutes	Exhaust fan blades	Bag packer augers
Ash conveyor elbow	Post hole diggers	Brick augers
Blast hole augers	Wet ash centrifugal pumps	Feeder blades
Ore or coal chutes	bag packer screws	Pug mill augers

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"(15-25mm)	1"-1½"(25-35mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA

While all sizes of Postalloy 284-SPL will easily operate with or without a gas cover, you may find applications for .045 and 1/16 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