

# 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® 285-SPL

### Description

Postalloy 285-SPL is a high alloy austenitic manganese steel welding wire for joining, build-up or hardfacing. Produces high-strength, crack resistant deposits that are tough, ductile and work-harden rapidly. The high yield strength reduces mushrooming from impact. Unlike common manganese alloys, which should not be used for welding plain carbon steel, Postalloy 285-SPL can be used with full confidence to buildup or join manganese steels as well as manganese to carbon and low alloy steels.

### Specifications

**Wire Type:** Metal-cored, Gas-shielded.  
Weld Deposits are slag-free.

#### Weld Deposit Properties:

Tensile Strength .....135,000psi  
Yield Strength.....90,000psi  
Elongation.....30%  
Hardness as deposited.....20

### Applications

Welding manganese steel to itself	Pulverizing hammers
Railroad crossovers and frogs	Clam shell buckets lips
Crusher jaws	Dragline and power shovel bucket lips and teeth
Cone and roll shells	Sizing screens
Hammer mill hammers	Grizzly bars

### Welding Parameters - Use DC Reverse Polarity

	SHORT-ARC		SPRAY-ARC		PULSED SPRAY ARC WELDING					
	.045	1/16	.045	1/16	Use 98/2 Argon/Oxygen with 120pps					
						.045			1/16	
Amps	90-200	150-220	200-325	300-375	Current	130	160	225	180	300
Volts	15-21	18-21	27-30	27-30	Peak Amps	300	400	450	350	450
Gas	Ar/CO2	Ar/CO2	Ar/Ox	Ar/Ox	Volts	20	23	25	25	28
CFH	25-30	25-30	40-45	40-45	CFH	40-45		40-45		
Stick-out	1/2"(12mm)	3/4"(18mm)	5/8"(15mm)	3/4"(18mm)	Stick-out	5/8"(15mm)		3/4"(18mm)		

When welding out-of-position, use the lower ranges of voltages and amperages: 16-19 volts and 100-150 amps.

### Packaging

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

Also available as a flux-cored, open-arc wire - **Postalloy 285-FCO**.

Alternative welding electrode - **Postalloy 207**