

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® 2850-FCO

Description

Work-hardening austenitic manganese flux-cored wire, alloyed with chromium and nickel for improved weld deposit properties over standard manganese alloys. It is designed for build-up, hardfacing and fabricating of manganese steel. Deposits are very tough, and work-harden rapidly in-service as plastic deformation occurs during impact.

Specifications

Wire Type: Flux-cored, open-arc

Weld Deposit Properties:

Tensile Strength120,000psi
Yield Strength75,000psi
Elongation..... 45%
Hardness as deposited..... 15 - 20 Rc per ASTM E.18.0 & MIL 2-540.0
Work-hardened.....50 - 55 Rc per ASTM E.18.0 & MIL 2-540.0
Can be flame cut

Applications

Crusher jaws	Hammer mill hammers
Cones and roll shells	Impact breaker bars
Gyratory crusher mantels	Joining of manganese steel components.

Welding Parameters - Use DC Reverse Polarity and Globular Metal Transfer

Diameter	.045" (1.2mm)	1/16"(1.6mm)	7/64"(2.8mm)
Current <i>amps</i>	100-200	150-300	200-400
Voltage (DCRP) <i>volts</i>	19-27	23-28	23-30
Stickout <i>inch (mm)</i>	3/4"-1 1/2"(18-25mm)	1"-1 1/2"(25-35mm)	1 1/2"(40mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA	NA

Out-of-position - When welding out-of-position it is best to use a shielding gas of 100% CO₂ at 40-45 cfh and DC Straight Polarity. Welding should proceed vertical-down with 1" wide weave beads.

Packaging

Diameter	.045" (1.2mm)	1/16" (1.6mm)	7/64" (2.8mm)
25 Lb. Spools	Standard	Standard	NA
55 Lb. Coils	NA	Available	Standard
110, 220 Lb. Drums	Available	Available	Standard

Alternative Welding Electrode - **Postalloy 205**