

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 285-FCO

Description

Postalloy 285-FCO 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

Specifications

Wire Type: Flux-cored, Open-arc.

Weld Deposit Properties:

Tensile Strength:135,000 psi
Yield Strength:90,000 psi
Elongation:30%
Hardness as deposited:20 Rc
Work-hardened:50 - 55 Rc
Deposits can be flame-cut
Cannot be machined

Applications

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

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	200-450
Voltage (DCRP) <i>volts</i>	21-27	23-28	23-30
Stickout <i>inch (mm)</i>	3/4"-1 1/4"	1"-1 1/2"	1 1/2"
Gas Flow <i>cfh (l/hr)</i>	NA	NA	NA

If a gas cover is desirable, use 100% CO₂ at 40-45 cfh. This will cause amperages to go up by about 10%. The stick out should be shortened. When welding out-of-position, use the lower ranges of voltages and amperages.

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 207