

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® 2866-FCO

Description

Postalloy 2866-FCO is a flux-cored, open-arc high chromium, nickel, moly alloy that produces deposits with excellent strength and elongation, combined with a high degree of toughness. Weld deposits work-harden in service and provide outstanding impact resistance. The austenitic structure of the weld deposit provides very good corrosion resistance. It's versatility allows it to be used for joining, as well as a cushion layer prior to hardfacing with a harder, more wear resistant alloy.

Use on carbon and alloy steels, stainless and manganese steels and joining dissimilar combinations.

Specifications

Wire Type: Flux-cored, open arc.

Weld Deposit Properties:

Tensile Strength:100,000 psi
Yield Strength:.....78,000 psi
Elongation:25%
Hardness as deposited100-150 Rb
Work-hardened.....30-35 Rc
Deposits cannot be flame-cut
Deposits are machinable

Welding Parameters - Use DC Reverse Polarity and Globular Metal

Diameter	.045" (1.2mm)	1/16"(1.6mm)
Current <i>amps</i>	150-200	180-250
Voltage (DCRP) <i>volts</i>	25-28	27-29
Stickout <i>inch (mm)</i>	1"-1¼"(25-30mm)	1½"(40mm)
Gas Flow <i>cfh (l/hr)</i>		

If a gas cover is desirable use Argon/CO2 or 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)
25 Lb. Spools	Standard	Standard

Alternative Welding Electrode - Postalloy 206HD