

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® 286-FCO

Description

Postalloy 286-FCO is an iron base high chromium, nickel, moly alloy designed for applications involving high temperature wear, impact, metal-to-metal wear and thermal shock. Weld deposits work-harden in service and provide outstanding impact and wear resistance up to 1100°F (595°C), and are fully machinable. Applications include shear blades, tong bits, hot metal ladles, mill guides, hot-forming tools, extrusion dies.

Specifications

Wire Type: Flux-cored, open arc.

Weld Deposit Properties:

Hardness as deposited20 Rc
Work-hardened40 - 45 Rc
Heat Resistance up to1100°F(595°C)
Deposits cannot be flame-cut
Deposits are machinable

Applications

Shear blades
Tong bits
Hot metal ladles
Sintering plant parts

Welding Parameters - Use DC Reverse Polarity and Globular Metal Transfer

Diameter	.045" (1.2mm)	1/16" (1.6mm)
Current <i>amps</i>	120-180	150-250
Voltage (DCRP) <i>volts</i>	24-28	24-28
Stickout <i>inch (mm)</i>	1"-1¼"(25-30mm)	1½"(40mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA

If a gas cover is desirable, use Argon/CO2 at 40 cfh or 100% CO2. 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