POSTLE INDUSTRIES, INC.

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POSTALLOY®

Data Sheet

POSTALLOY® 2893-SPL

Description

POSTALLOY 2893-SPL is a high hardness, machinable gas-shielded hardfacing wire. It provides high compressive strengths and the wear life will far exceed conventional build-up alloys and mild steel. Weld deposits are exceptionally sound and dense, and heavy build-ups are possible without danger of cracking(preheat may be necessary for certain low alloy, higher carbon steels). Use on carbon and alloy steels

Specifications

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

Weld Deposit Properties:
Hardness: 40 - 45 Rc
Maximum Deposit Thickness: Unlimited
Preheat may be required for certain low alloy, higher carbon steels
Deposits can be flame cut

Applications

- Spindles
- Wobblers
- Work roll sprockets
- Cable sheaves
- Gears and keyways
- Ladle turnnions
- Conveyor chain links
- Shovel carrier rollers
- Driving sprockets
- Driving tumblers
- Tractor undercarriage idlers and rollers
- Trencher drive segments and rollers
- Dredge bucket pins
- Dredge driving tumblers
- Ladder rolls
- Lower tumblers
- Bulldozer trunnions
- Continuous miner bearing carrier
- Shaker conveyor rails
- Shaker pan conveyor

Welding Parameters - Use DC Reverse Polarity

	SHORT-ARC		SPRAY-ARC	
	.045	1/16	.045	1/16
Amps	90-200	150-220	250-325	300-375
Volts	15-21	18-21	27-30	27-30
Gas	Ar/CO2	Ar/CO2	Ar/Ox	Ar/Ox
CFH	25-30	25-30	40-45	40-45
Stick-out	1/2"(12mm)	3/4"(18mm)	5/8"(15mm)	3/4"(18mm)

PULSED SPRAY ARC WELDING
Use 98/2 Argon/Oxygen with 120pps

	.045			1/16		
Current	200	220	250	250	275	300
Peak Amps	350	375	425	350	375	400
Volts	24	25	26	24	25	26
CFH	40-45			40-45		
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	Available