

# 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

## POSTALLY® 2898®-SPL

### Description

A general purpose self-hardening overlay with a good combination of resistance to abrasion and impact Postalloy 2898-SPL is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100°F(595°C).

### Specifications

**Wire Type:** Metal-cored, gas-shielded  
Deposits are slag-free

**Weld Deposit Properties:**

Average Hardness: 55 -59 Rc  
Good Hot-hardness: up to 1100°F(595°C)  
Maximum overlay: 2 - 3 layers  
Non-Machinable: must be ground

### Applications

Hot Shear Blades	Dozer Blades
Shearing and piercing dies	Bucket Teeth
Farm Implements	Augers

### Welding Parameters - Use DC Reverse Polarity (DCEP)

	SHORT-ARC		SPRAY-ARC		PULSED SPRAY ARC WELDING						
	.045	1/16	.045	1/16	Use 98/2 Argon/Oxygen with 120pps						
Amps	90-200	150-220	250-325	300-375	Current	200	220	250	250	275	300
Volts	15-21	18-21	27-30	27-30	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO <sub>2</sub>	ArCO <sub>2</sub>	Ar/Ox	Ar/Ox	Volts	24	25	26	24	25	26
CFH	25-30	25-30	40-45	40-45	CFH	40-45			40-45		
Stick-out	1/2"(12mm)	3/4"(18mm)	5/8"(15mm)	3/4"(18mm)	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	Standard
50 lb. Spools	Available	Available
55 lb Coils	NA	Available
110 and 220 lb Drums	Available	Available

Also available as a flux-cored, open-arc wire - **Postalloy 2898-FCO**  
Alternative Welding Electrode - **Postalloy 27**