

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 2898-FCO

Description

Postalloy 2898-FCO is a general purpose flux-cored, open-arc hardfacing wire providing a good combination of abrasion resistance and toughness. Use to overlay carbon and low alloy steel, manganese steel, stainless steel and cast iron.

Specifications

Wire Type: Flux-cored, Open-arc

Weld Deposit Properties:

Hardness: 55-59 Rc

Maximum overlay: 2-3 layers

Non-machinable - must be ground

This alloy may relief check (depending on type of base metal, thickness, etc.)

Applications

Tillage tools

Conveyor screws

Backhoe

Clamshell

Shovel and dragline bucket lips and teeth

Tractor rousers

Bulldozer blades and end bits

Dragline scrapers

Dragline chain idlers

Agitator bearings and shafts

Sprockets

Gudgeon hangers and pins

Welding Parameters

Diameter	.045"(1.2mm)	1/16"(1.6mm)	7/64"(2.8mm)
Current <i>amps</i>	100-200	150-300	325-500
Voltage (DCRP) <i>volts</i>	21-27	23-28	25-30
Stickout <i>inch (mm)</i>	3/4"-1 1/4"(18-30mm)	1"-1 1/2"(25-40mm)	1"-1 1/2"(25-40mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA	NA

Packaging

Diameter	.045"(1.2mm)	1/16"(1.6mm)	7/64"(2.8mm)
25 Lb. Spools	Standard	Standard	NA
55 Lb. Coils	NA	NA	Standard

Also available as a metal-cored, gas-shielded wire - **Postalloy 2898-SPL**

Alternative Welding Electrode - **Postalloy 21**