

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 2899-SPL

Description

A multi-purpose hard overlay with good abrasion resistance, excellent toughness and good metal to metal wear characteristics. Deposits are not brittle and will maintain a good cutting edge without chipping. Deposits retain their hardness 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

- Shear Blades
- Trim Dies
- Shearing and piercing dies
- Cutting tools
- Recycling knives

Welding Parameters - Use DC Reverse Polarity

	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 ₂	ArCO ₂	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)			

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