

# POSTLE INDUSTRIES, INC.



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Data Sheet

## POSTALLOY® 299-SPL

### Description

Postalloy 299-SPL is an open-arc hardfacing overlay that utilizes a specially formulated tungsten carbide to produce a "highly feathered" microstructure that is unusually hard and more abrasion resistant than standard tungsten carbide hardfacing wires. Operates at lower than normal currents to minimize dilution and help develop its high hardness and unique microstructure in the first layer. For extreme earth abrasion resistance with little or no impact.

### Specifications

**Wire Type:** Metal-cored, open-arc  
Deposits are slag-free

#### Weld Deposit Properties:

Hardness: Tungsten Carbide - 2300 HV  
Matrix Alloy: 60-65 Rc  
Deposit Thickness: 2 layers maximum  
Deposits will readily relieve check-crack

### Welding Parameters

Diameter	1/16"(1.6mm)	3/32"(2.4mm)
Current <i>amps</i>	120-240	250-350
Voltage (DCRP) <i>volts</i>	23-26	23-26
Stickout <i>inch (mm)</i>	1"-1½"(25-35mm)	1½"(40mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA

### Packaging

Diameter	1/16"(1.6mm)	3/32"(2.4mm)
25 Lb. Spools	NA	Standard