

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 305

Description

POSTALLOY 305 is designed to weld low alloy, high strength steel such as T-1, Hy-90, Hy-100, SSS-100. An all-position electrode that provides crack-free welds under highly stressed conditions with outstanding elongation and ductility. Easy slag removal.

Specifications

Tensile Strengthup to 113,000 psi
Yield Strengthup to 104,000 psi
Elongation20%

Applications

Used to fabricate tanks, containers, covers, and high strength pipe. Use for welding low alloy steels containing manganese, nickel, molybdenum, and chromium such as I-beams, angle iron, scaffolding and super structures. Weldments can be used as welded or stress relieved.

Welding Procedures - Use AC or DC Reverse Polarity

Preheat is unnecessary when welding low carbon steels. A preheat of 400° - 600°F (200° - 300°C) is recommended when joining heavy sections to thin sections and low alloy or higher carbon steels are welded. Maintain a short arc and use stringer or weave beads. Allow deposit to cool before chipping off slag. Heat to 1025°F (550°C) and maintain for 1 hour to stress relieve.

Diameter	1/8 (3.2mm)	5/32 (4.0mm)	3/16 (4.8mm)
Current <i>amps</i>	100-150	120-210	200-275

Also available as a flux-cored wire - **Postalloy 3044-FCG**