

# POSTLE INDUSTRIES, INC.



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## Data Sheet

### POSTALLOY® 306-FCO

#### Description

**POSTALLOY 306-FCO** is a medium carbon, high strength flux-cored, open-arc wire designed for butt, fillet and lap welding of low carbon and low alloy steels. Recommended for single and multi-pass welding applications in **all positions**. Use on steel thicknesses from 16 gauge up to 3/4". When welding steels over 1/2" a preheat of 300°F (149°C) is recommended.

It is a versatile, easy to use welding wire with excellent operator appeal. Without the need for shielding gas, **POSTALLOY 306-FCO** is ideal for welding applications in which the addition of gas is impractical, or where windy and other adverse conditions prevail. It is not recommended for low temperature applications.

#### Weld Deposit Properties:

Tensile Strength ..... 100,000 psi  
Elongation ..... 22%  
Smooth arc action and low spatter  
Ideal for high deposition requirements  
Excellent out-of-position weldability

#### Applications

**POSTALLOY 306-FCO** should be used for fabricating structural shapes such as "I" and "H" beams, channels, plates and pipes. Installation of wear plates, maintenance of mining and construction equipment, fabrication of hoppers and tanks.

**Welding Parameters:** Use DC reverse with spray type transfer.

.045" Flat	14 - 18 volts, 100 - 250 amps, 1/2" stick-out
	Vertical-up and overhead 14 - 16 volts, 100 - 200 amps, 1/2" stick-out
1/16" Flat	17 - 20 volts, 150 - 300 amps, 1/2" - 3/4" stick-out
	Vertical-up and overhead 16 - 18 volts, 150 - 250 amps, 1/2" - 3/4" stick-out

#### Packaging

Diameter	.045"(1.2mm)	1/16"(1.6mm)
25 lb Spools	Standard	Standard