

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 30

Description

POSTALLOY 30 is a high strength, ductile, crack resistant welding alloy specifically designed for welding problem steels such as, low alloy, high carbon or crack sensitive tool steels. Ideal for welding dissimilar steels - low alloy, spring steels, carbon steels, tool steels.

EXCELLENT JOINING CHARACTERISTICS - With the combination of balanced alloy chemistry and high strength, crack resistant weld deposits, the capability to weld dissimilar problem steels is outstanding.

CARBON HAS NO ADVERSE AFFECTS - Carbon, the cause of most problems associated with weld cracking and hard spots, is rendered harmless.

ACTS AS A SHOCK ABSORBER DURING OPERATION - Since **POSTALLOY 30** does not respond to heat-treatment and remains ductile, it has the ability to withstand heavy impact or shock loading.

Specifications

Tensile Strengthup to 120,000 psi
Elongation35%
Machinable with Carbide Tools
Cannot be flamecut

Applications

Shafts and keyways, gear tooth build-up, stamping and forging dies, shovel teeth and blades, wear plates, grousers, heat-treating parts, cracked steel casings, jigs and fixtures and chain links.

Welding Procedures - AC or DC Reverse Polarity

Clean weld area of contaminants. Remove any defective or fatigued weld metal. Bevel heavy sections 90°. Tilt the electrode about 15° in the direction of travel and use the lowest amperage possible. For certain high alloy steels, a preheat of 300°-400°F (149°-204°C) is recommended. Hold a short arc and use stringer beads. Peen to reduce stresses. Allow to cool and remove slag.

Diameter	3/32 (2.5mm)	1/8 (3.2mm)	5/32 (4.0 mm)
Current <i>amps</i>	50-80	80-125	100-150

Also available as a bare wire for heliac - **TIGWELD 30-B** and as semi-automatic welding wire **30-SPL** and **30-FCG**