

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 30-SPL

Description:

POSTALLOY 30-SPL is a high strength, crack resistant gas shielded solid wire 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 a combination of balanced alloy chemistry, high strength and crack resistance, the capability to weld dissimilar problem steels is outstanding.

CARBON HAS NO ADVERSE AFFECTS - Brittle, carbon rich areas, the cause of most problems associated with welding higher carbon steels, are eliminated when using this alloy.

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

Weld Deposit Properties:

Tensile Strength.....120,000 psi
Elongation.....35%
Machinable with Carbide Tools
Deposits cannot be flamecut

Welding Parameters: Use DC Reverse Polarity.

POSTALLOY 30-SPL can be used in short-arc with Argon/CO₂(75/25) or in spray-transfer with Argon/Oxygen(98/2). Recommended gas flow is 40 - 50 cfh. Use short-arc welding for thinner materials, root passes and welding out-of-position. Use spray transfer for welding in the flat position.

.045" - 75 to 300 amps, 16 to 27 volts, 1/2" - 5/8" stick-out

Packaging

Diameter	.045"(1.2mm)
5 lb Spools	Standard
30 lb Spools	Standard