

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® 344

Description

POSTALLOY 344 is an “all new” high strength mild steel electrode offering very smooth operation coupled with superior out-of-position weldability and penetration. It is ideal for welding thin, medium, heavy and dissimilar gauge steel.

Easy “all position” weldability - Never before has an electrode been made that offers both smooth operating features with such as outstanding ability to weld out-of-position. Welding positions such as vertical up and down, flat or horizontal fillets, and overhead can be easily accomplished.

Ideal for poor-fit work - With **POSTALLOY 344** you won't have to spend time positioning the work to make a perfect joint. With its quick-freezing slag and steady arc, it will easily bridge or fill a gap.

Best of all - POSTALLOY 344 won't burn you up. Good penetration does not mean that the sparks have to fly and this is especially true with **POSTALLOY 344**.

Specifications

Tensile strength84,000 psi
Elongation24%

Applications

POSTALLOY 344 is ideal for contaminated, dirty steels where surface conditions are poor and surface preparation is impractical. The scavenging action of the coating floats contaminants to the surface creating a solid, porosity-free weld.

Welding Procedures - AC or DC Reverse Polarity

Although it is best to clean the surface prior to welding, **POSTALLOY 344** will weld through rust, paint and other contaminants when it is necessary. Amperages should be increased slightly. When welding thin materials, use the lowest possible amperage and maintain close arc. **POSTALLOY 344** may be used with a drag technique or with a gap.

Diameter	3/32 (2.5mm)	1/8 (3.2mm)	5/32 (4.0mm)
Current <i>amps</i>	40-80	70-125	120-175