

POSTLE INDUSTRIES, INC.

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Data Sheet

POSTALLOY® 540-MCG

Description

Postalloy 540-MCG is an iron base alloy designed for the buildup and overlay of gray cast iron components, typically Class 20 to Class 50. **Postalloy 540-MCG** is most often used to rebuild worn components back to original size, or as an underlayment prior to putting a harder more wear resistant alloy on top of. If you are repairing broken or cracked components, it is advisable to use a high nickel alloy, such as Postalloy 53-SPL (wire) or Postalloy 50 (electrode).

The hardness of **Postalloy 540-MCG** is influenced by the amount of weld mixed with the base metal and the cooling rate of the weld. It is advisable to use a low preheat to avoid thermal shocking the base metal, at least 150°F. When welding on gray iron a preheat of 150°F-200°F will produce a hardness in the range of 300BHN to 400BHN. If a preheat of 300°F-500°F is used, the hardness will range between 200BHN to 300BHN, it is advisable to weld with low amperage and voltage settings to reduce weld dilution.

Specifications

Wire Type: Metal-Cored, Gas-shielded
Deposits are slag-free

Weld Deposit Properties:

Maximum Deposit Thickness: Unlimited
Deposits can be flame cut
Deposits are machinable

Welding Parameters - Use DC Reverse Polarity

	.045	1/16
Amps	200-240	220-260
Volts	23-27	25-27
Gas	75% Ar/25% CO2	75% Ar/25 % CO2
CFH	35-40	35-40
Stick-out	1/2"(12mm)	3/4"(18mm)

Packaging

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