

POSTLE INDUSTRIES, INC.

P.O. Box 42037 • Cleveland, Ohio 44142

Fax: 216-265-9030 • Phone: 216-265-9000 • Toll Free: 800-321-2978

E-Mail: sparky@postle.com • Web Site: www.postle.com



A Tungsten Carbide Matrix Wire For Carbide Embedding

Data Sheet

POSTALLOY® PS-98

Description

Postalloy PS-98 is a metal cored, triple deoxidized Iron based wire, alloyed with Chromium and Tungsten. This product is primarily used as a matrix alloy for the Tungsten Carbide embedding process. Unlike soft mild steel welding wires, which are commonly used in the embedding process, the microstructure of *PS-98* is designed to encapsulate and protect the Tungsten Carbide particles from premature erosion. Many of the common embedding wires are solid which

require high voltage and amperage setting to achieve a fluid puddle. *Postalloy PS-98* is metal cored and develops a spray transfer at very low current levels. This combined with its unique alloy content forms a very fluid weld puddle. This promotes an even dispersion of Tungsten Carbide particles within the weld puddle. These unique properties make it an ideal choice when used with the Tungsten Carbide embedding process.



Hardness impression
in a PS 98 Matrix
58Rc



Hardness impression in
a Tungsten Carbide Particle
70Rc

Welding Parameters & Packaging

Diameter	.045" (1.14mm)	1/16" (1.6mm)
Polarity	DC Reverse	DC Reverse
Current <i>amps</i>	170-220	180-250
Wire Speed	180-210	160-190
Voltage (DCRP) <i>volts</i>	26-28	27-29
Gas Shielding (98% Argon / 2% Oxygen)	35 <i>cfh</i>	35 <i>cfh</i>
Stickout <i>inch (mm)</i>	1-1 1/4" (25-32)	1 to 1 1/4" (25-32)
Preheat	450/550°F (230/290°C)	450/550°F (230/290°C)
Hardness (1 Layer)	55 to 60Rc	55 to 60Rc

Deposits are slag free

Packaging.....25 & 50 Lb Spools.....25 & 50 Lb Spools