

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® PS 133

Description

POSTALLOY® PS 133 is a large diameter, metal cored, self shielding, hardfacing wire for use in a wide range of applications where abrasion is severe, including overlay plate production, the rebuilding of coal & cement clinker pulverizer rolls and tables, mining and agricultural ground engaging equipment such as bucket teeth, rippers, subsoilers and injector knives. Deposits are ultra high in carbon and chromium, ensuring maximum carbide population and wear protection, even on the first layer. The large diameters are ideal for automated applications where maximum deposit rates are required.

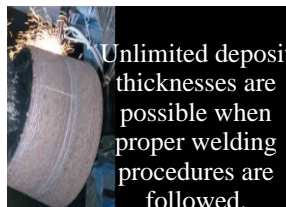
Specifications

Chemistry6.0C 28.0Cr 2.75Mn 0.8Si Bal. Fe
Hardness58 to 62 Rc
Heat Resistant toExcellent up to 1200°F (650°C)
Deposit thickness.....2 layers (*multiple layers possible with proper technique*)
Weld deposits will relief check crack readily
Deposits cannot be machined or forged.

Applications



Overlay Plate



Crusher Rolls



Mining Equipment



Ag Equipment

Deposits up to
1/2" thick are
possible

Unlimited deposit
thicknesses are
possible when
proper welding
procedures are
followed.

Welding Parameters

| | | | |
|-------|--------------|-------------|-----------------------|
| 7/64" | 400/600 Amps | 28/32 Volts | 1 to 1-1/4 " Stickout |
| 1/8" | 450/650 Amps | 30/34 Volts | 1 to 1-1/2" Stickout |

Packaging

55 lb. Coils 110 Lb. Drums 220 Lb Drums 500 Lb Drums