

# POSTLE INDUSTRIES, INC.



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## Data Sheet

# POSTALLOY® SUPER-EDGE

## Description

Postalloy Super-Edge is an abrasion resistant, gas shielded, high speed tool steel wire designed for applications where edge retention is a primary concern. Weld deposits are martensitic with micro-carbides evenly dispersed throughout the deposit. These properties create a fracture resistant cutting edge even under high compressive loads.

Postalloy Super-Edge is alloyed with molybdenum and tungsten for superior high temperature hot hardness. This property helps maintain a sharp edge under localized high heat conditions created by extreme friction. Super-Edge has very good build-up characteristics which is especially helpful when welding along edges.

## Specifications

**Wire Type:** Metal-cored, gas-shielded

### Weld Deposit Properties

Average Hardness: 60 - 65 Rc per ASTM E.18.0 + MIL 2-540.1

Good Hot-hardness: up to 1150°F(620° C)

Maximum overlay: 2 - 3 layers

Non-Machinable: must be ground

## Applications

Hot or cold trim dies

Blanking dies

Shearing and piercing dies

Shear blades

Cutting tools

Tire recycling knives

## Welding Procedures:

Surface should be clean and free of mill scale and any other foreign matter. Cleaning by grinding or machining is preferable. Inspect for cracks or fatigued metal and remove all defective material. A suitable preheat and postheat temperature depends upon the base metal type, thickness, and sometimes the condition of the base metal heat treatment. Preheat to a minimum of 500°F(260°C) and a maximum of 900°F(480°C). Consult Postle Industries for specific recommendations. Maintain original preheat temperatures when welding. Slow cooling in a hot box is preferable.

## Welding Parameters - Use DC Reverse (DCEP) or DC Straight Polarity (DCEN)

	SHORT-ARC	SPRAY-ARC	PULSED SPRAY ARC WELDING	
			Use 98/2 Argon/Oxygen with 120 pps	
Amps	160-200	250-390	Current	180-300
Volts	19-22	28-30	Peak Amps	350-450
Gas	Ar/CO <sub>2</sub>	Ar/Ox	Volts	25-28
CFH	30-35	40-45	CFH	40-45
Stick-out	1/2-3/4"(12-18mm)	3/4"(18mm)	Stick-out	3/4"(18mm)

## Packaging

Diameter	.045"(1.2mm)	1/16"(1.6mm)
25 lb. Spools	Standard	Standard
50 lb. Spools	Available	Available
55 lb Coils	NA	Available
110 and 220 lb Drums	Available	Available