

POSTLE INDUSTRIES, INC.



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Data Sheet

POSTALLOY® Durachrome-G

Description

A premium metal-cored, gas-shielded chromium carbide hardfacing alloy that has a high volume fraction of carbides dispersed in a hard matrix. Excellent out-of-position weldability. For applications involving high abrasion and mild or moderate impact. Deposit polish in service and are heat resistant to 1000°F(531°C). Use on carbon and low alloy steels.

When used with 100% CO₂ or 75/25 Argon/CO₂, it offers excellent weldability in flat, horizontal and vertical down positions, the arc is very stable at both high and low voltages settings, and the smoke level is very low.

Specifications

Wire Type: Metal-cored, gas-shielded
Deposits are slag-free

Weld Deposit Properties:

Average Hardness: 58 - 62 Rc per ASTM E.18.0 & Mil 2540.0

Deposit Thickness: 1 to 2 layers

Deposits cannot be flame cut

Deposits will check-crack to relieve stresses

Applications

Scrapper blades

Road ripper teeth

Bucket teeth bucket sides and bottoms

Tillage tools

Auger flights

Screw conveyors

Mixer blades

Fan blades

Coal feeder screws

Welding Parameters - DC Reverse Polarity

Diameter	.045" (1.2mm)
Current <i>amps</i>	140-260
Voltage (DCRP) <i>volts</i>	18-26
Stickout <i>inch (mm)</i>	3/4"-1"(18-25mm)
Gas Flow <i>cfh (l/hr)</i>	NA

When welding out of position, use .045 with reverse polarity and the lower range of amperages and voltages. Weld vertical down with 3/4"(18mm) wide weave beads.

Packaging

Diameter	.045" (1.2mm)
25 Lb. Spools	Standard
55 Lb. Coils	NA
110, 220 Lb. Drums	Available

Alternative Welding Electrode - **Postalloy 214**