

# POSTLE INDUSTRIES, INC.



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Data Sheet

## POSTALLOY® PS 164

### Description

A martensitic tool steel type alloy with numerous tightly packed carbides for excellent abrasion resistance under high impact. Deposits are smooth and free of any slag. One layer deposits exhibit wear characteristics that you would expect from chromium carbide hardfacing products. An excellent choice for applications requiring crack free deposits with good wear characteristics. Also an excellent wire for MIG Carbide

### Specifications

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

**Weld Deposit Properties:**

Average Hardness: 57-61 Rc  
Good Hot-hardness: up to 1100° F(595°C)  
Maximum overlay: 2 - 3 layers  
Non-Machinable: must be ground

### Applications

Plow Shares	Dozer Blades
Sub-soilers	Bucket Teeth
Farm Implements	Augers

### Welding Parameters - Use DC Straight Polarity (DCEN)

	SHORT-ARC		SPRAY-ARC		PULSED SPRAYARC WELDING						
	.045	1/16	.045	1/16	Use 98/2 Argon/Oxygen with 120pps						
Amps	90-200	150-220	250-325	300-375	Current	200	220	250	250	275	300
Volts	15-21	18-21	27-30	27-30	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO <sub>2</sub>	ArCO <sub>2</sub>	Ar/Ox	Ar/Ox	Volts	24	25	26	24	25	26
CFH	25-30	25-30	40-45	40-45	CFH	40-45			40-45		
Stick-out	1/2"(12mm)	3/4"(18mm)	5/8"(15mm)	3/4"(18mm)	Stick-out	5/8"(15mm)			3/4"(18mm)		

When welding out-of-position, use the lower ranges of voltages and amperages: 16 - 19 volts and 100 - 150 amps.

### 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