

POSTLE INDUSTRIES, INC.



P.O. Box 42037 • Cleveland, Ohio 44142

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

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

POSTALLOY 2812-SPL POSTALLOY 2813-SPL POSTALLOY 2814-SPL

METAL-CORED, GAS-SHIELDED NICKEL BASE
OVERLAYS OFFERING ABRASION, CORROSION,
HEAT AND METAL-TO-METAL WEAR RESISTANCE

CHARACTERISTICS:

Weld deposits of these alloys consists of borides and chromium carbides in a nickel matrix for excellent resistance to low stress abrasion and metal-to-metal wear. The high nickel and chromium content gives these weld deposits good heat and corrosion resistance.

These alloys are metal-cored, gas-shielded wires designed for application by GMAW. Deposits are smooth with no slag to chip and no ripples. They may be applied to cast iron, carbon and alloy steels, stainless steel, and nickel alloys.

Weld deposits of these alloys offer the same general properties with the essential difference being the hardness and wear resistance

Excellent sliding, metal-to-metal wear resistance with unusually good resistance to galling.

Very good resistance to atmospheric, steam and salt water corrosion.

Excellent heat resistance - deposits maintain their hot-hardness up to 1000°F(538°C).

Deposits are non-sparking, non-heat-treatable, and non-magnetic.

POSTALLOY 2812-SPL - Deposits are fully machinable. Hardness - 35 to 40Rc.

POSTALLOY 2813-SPL - Best for applications involving abrasion with moderate impact. Deposits are best finished by grinding. Hardness - 45 to 50Rc.

POSTALLOY 2814-SPL - Best for severe wear and abrasion, and applications involving metal-to-metal wear. Hardness - 55 to 60Rc.

TYPICAL APPLICATIONS:

Shafts, sleeves, pump parts, impellers, bushings, gauges, guides, cams, rocker arms, screw flights, seal rings, splines, roll guides, lathe centers, conveyor guides.

WELDING PARAMETERS: Use DC Reverse Polarity

For short-arc welding use Argon/CO, 16 - 23 volts and 80 - 200 amps. For Spray-arc welding use Argon/Oxygen, 29 - 33 volts and 220 - 250 amps.

SIZES AND AMPERAGES:

.045 x 5 and 25 lb spools