

POSTALLOY® 219HD



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Description

When protection with tungsten carbide is needed, POSTALLOY® 219HD is an ideal choice. Weld deposits contain tungsten carbide in a chromium rich matrix for added wear and corrosion protection. Other outstanding features include:

- Easy out-of-position weldability with the 6mm diameter
- Excellent AC or DC operation, even on a "buzz box"
- High metal recovery - no slag to chip
- Low amperage - 6mm from 80 amps
- High deposition rates - up to 3 times faster than ordinary electrodes
- Moisture resistant coating, even under severe weather or high humidity POSTALLOY® 219HD

hardfacing is a unique concept in hard facing technology and is over 90% efficient. Its tubular design offers very smooth operational characteristics and permits higher travel speeds and much higher percentages of carbide forming elements contained in the core as compared to ordinary flux-coated electrodes.

Specifications

Product Type: Electrode

Weld Deposit Properties

Hardness: 64 - 68 Rc
Deposit thickness: 2 layers
Relief checks readily to prevent stress buildup.
Cannot be flame cut.

Applications

Auger points	Bucket pin ends
Debarking hammers	Shredder knives
Cutter teeth	Ditcher teeth
Anvil knives	Muller plows
Flights	Dredge bucket lips
Tamping tools	Fan blades
Pilot bits	Dredge teeth
Sand slinger cups and impeller tips	Churn drills
Mixer paddles and blades	Fly ash conveyors
Dragline chains	Cable tool core heads
Screw conveyors	

POSTALLOY® 219HD Welding Parameters

Current: AC or DC Polarity

Diameter	Amps
6mm	80 - 130

Packaging Options

Diameter	Standard Packaging
6mm	Resealable Plastic Box

Diam.	4.54kg Pack
6mm	PHF219HD

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