

# POSTALLOY® 2892-SPL (350-G)



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## Description

Medium hardness buildup wire with excellent compressive strength. Recommended for applications where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as welded". Use on carbon and low alloy steels.

## Specifications

**Product Type:** Metal-Cored, Gas-shielded

Deposits are slag-free.

Also available as a flux-cored, open-arc wire - Postalloy 2892-FCO

## Weld Deposit Properties

Hardness: 33 - 38 Rc

Maximum Deposit Thickness: Unlimited

Deposits can be flame cut

Machinable with carbide tools

## Applications

Machine components

Gear teeth

Steel mill parts

Keyways

Undercarriage Carbon steel railroad track components

Parts of earth moving and mining equipment

## POSTALLOY® 2892-SPL Welding Parameters

**Current:** Use DC Reverse Polarity

Short Arc	Amps	Volts	Gas	L/min	Stick Out
1.2mm	90-200	15-21	Ar/CO2	12-14	12mm
1.6mm	150-220	18-21	Ar/CO2	12-14	18mm
Spray Arc	Amps	Volts	Gas	L/min	Stick Out
1.2mm	250-325	27-30	Ar/Ox	18-22	15mm
1.6mm	300-375	27-30	Ar/Ox	18-22	18mm
Pulsed Spray Arc	Current	Peak Amps	Volts	L/min	Stick Out
1.2mm	200/220/250	350/375/425	24/25/26	18-22	15mm
1.6mm	250/275/300	350/375/400	24/25/26	18-22	18mm

Use 98/2 Argon/Oxygen with 120 pulse/sec. When welding out-of-position, use the lower ranges of voltages and amperages: 16 - 19 volts and 100 - 150 amps.

## Packaging Options

Diameter	Standard Packaging
1.2mm	11.4 kg spool
1.6mm	11.4 kg spool

Diam.	11.34 kg Spool
1.2mm	PHF350G12

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