

POSTALLOY® 2747-FCG



Postle Industries • Cleveland, OH USA • Telephone: 216-265-9000 • Fax: 216-265-9030

Description

POSTALLOY® 2747-FCG is a tough iron base chrome/nickel/moly hot-working tool steel alloy. Alloy chemistry is balanced to provide weld metal with maximum wear resistance while still being machinable. Deposits reach maximum hardness as deposited and can be tempered to reduce stress. Weld deposits are shock-resistant and are highly resistant to heat-checking, oxidation and wear.

Specifications

Product Type: Flux-cored, Gas-Shielded

Weld Deposit Properties

Hardness: 44-49 HRc as-welded

Hardness: 44-47 HRc as-tempered

Applications

Repair of deformed, broken, spalled or heat checked areas of hydraulic presses and drop hammer forging dies. Filling medium deep impressions that are to be re-cut to dimensions

POSTALLOY® 2747-FCG Welding Parameters

Current: DC Reverse Polarity

Diameter	Amps	Volts	L/min	Stick Out
1.6mm	200-300	25 - 29	18-24	25mm

Gas Cover Options (for all wire sizes):

75/25 Argon/CO₂, 80/20 Argon/CO₂, 90/10 Argon/CO₂, 98/2 Argon/CO₂, CO₂ –Alternate

Packaging Options

Diameter	Standard Packaging
1.6mm	11.4kg spool

Diam.	11.4kg Spool
1.6mm	PHF2747-16

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