

POSTALLOY® 2512-SPL (Cobalt 12)



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Description

Conforms to AWS CoCr-B. Cobalt base alloy that is slightly harder and more wear resistant than 2506-SPL, but its impact resistance is somewhat lower. Also tougher to machine. Weld deposits also have a greater tendency to relief check if welding procedures are not closely monitored.

Specifications

Product Type: COBALT BASE HARDFACING ALLOYS
METAL - CORED, GAS - SHIELDED

Weld Deposit Properties Average hardness: 43- 46 Rc Deposit thickness: 2 layers
Deposits are non -machinable

POSTALLOY® 2512-SPL Welding Parameters

Current: Use DC Reverse(+) Polarity

Short Arc	Amps	Volts	Gas	CFH
1.2mm	80-160	15-23	Ar/CO2	18-22
Spray Arc	Amps	Volts	Gas	L/min
1.2mm	170-240	24-30	Ar/Ox	18-22

These wires operate over a wide range of settings and can be used in short-arc and spray transfer. CO₂ shielding gives the best control, but the most dilution and lowest hardness on first pass. Argon/CO₂(75/25) gives good control, a better bead appearance and higher first pass hardness. Spray-arc produces minimal dilution and high first pass hardness.

Packaging Options

Diameter	Standard Packaging
1.2mm	2.27 kg Spool

Diam.	2.27 kg Spool
1.2mm	PHF251212

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