

POSTALLOY® 51



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

Description

POSTALLOY® 51, for welding offers excellent weldability and highly crack resistant deposits. This is especially important for thin-walled castings and when maximum machinability is desired after one pass. Important features of POSTALLOY® 51 are:

- Controlled penetration provides sufficient force to penetrate through surface contaminants, but prevents excessive dilution.
- Low amperage minimizes the hard brittle zone around the weld.
- Outstanding machinability. Excellent wash and fluidity.
- Very good weld beat tie-in.
- Deposits are dense and porosity-free. POSTALLOY® 51 will not turn red and overheat, allowing full use of the electrode.

Specifications

Product Type: Electrode

Weld Deposit Properties

| | |
|------------------|-----------|
| Tensile Strength | 380 MPa |
| Machinability | Excellent |
| Hardness | 170 BHN |

POSTALLOY® 51 Welding Parameters

Current: AC or DC Reverse (+)

| Diameter | Amps |
|----------|---------|
| 2.5mm | 40-70 |
| 3.2mm | 65-110 |
| 4.0mm | 110-140 |

Welding Procedure

Veel out cracks and defective weld metal before commencing welding. When using POSTALLOY 51, maintain a short to medium arc length. The arc should be directed on deposited weld metal with the electrode tilted slightly in the direction of travel. Use stringer beads only - do not weave. Weld beads should be 25mm to 75mm long, craters to be filled by back whipping, and each pass should be peened immediately upon breaking arc. Remove slag by chipped and brushing. Allow part to cool slowly. Cover with a heat resistant blanket or lime if possible.

Packaging Options

| Diameter | Standard Packaging |
|----------|------------------------|
| 2.5mm | Resealable Plastic Box |
| 3.2mm | Resealable Plastic Box |
| 4.0mm | Resealable Plastic Box |

| Diam. | 4.54 kg Pack |
|-------|--------------|
| 2.5mm | PHF5125 |
| 3.2mm | PHF5132 |
| 4.0mm | PHF5140 |

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com