

POSTALLOY® 216HD



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Description

POSTALLOY 216HD hardfacing electrodes are a unique concept in hardfacing technology. They are tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes. Weld chemistry produces a chromium carbide deposit designed for overlaying surfaces exposed to high abrasion and medium impact. Carbides are dispersed throughout a tough alloy matrix that is both heat and impact resistant. Good hot-hardness up to 540°C. Due to its unique tubular design, POSTALLOY 216HD offers very smooth operational characteristics. Other outstanding features are:

- Easy out-of-position weldability
- Excellent AC or DC operation, even on a "buzz box"
- High metal recovery - no slag to chip. POSTALLOY 216HD is over 90% efficient
- 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

Specifications

Product Type: Electrode

Weld Deposit Properties

Hardness 59 - 62 Rc
Deposit Thickness 2 - 3 passes
Relief checks readily to prevent stress buildup.
Cannot be flame cut.

POSTALLOY® 216HD Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
6mm	80 - 120

Packaging Options

Diameter	Standard Packaging
6mm	Resealable Plastic Box

Diam.	4.54kg Pack
6mm	PHF216HD

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