

POSTALLOY® 2850-FCO (Mang-O/G)



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Description

Work-hardening austenitic manganese flux-cored wire, alloyed with chromium and nickel for improved weld deposit properties over standard manganese alloys. It is designed for buildup, hardfacing and fabricating of manganese steel. Deposits are very tough, and work-harden rapidly in-service as plastic deformation occurs during impact.

Specifications

Product Type: Flux-cored, open-arc

Weld Deposit Properties

Tensile Strength	830 MPa
Yield Strength	520 MPa
Elongation	45%
Hardness as deposited	15 - 20 HRc per ASTM E.18.0 & MIL 2-540.0
Work-hardened	50 - 55 HRc per ASTM E.18.0 & MIL 2-540.0
Can be flame cut	

Applications

Crusher jaws	Impact breaker bars
Hammer mill hammers	Gyratory crusher mantels
Cones and roll shells	Joining of manganese steel components

POSTALLOY® 2850-FCO Welding Parameters

Current: DC Reverse Polarity and Globular Metal Transfer

Diameter	Amps	Volts	Stick Out
1.6mm	150-300	23-28	25-35mm

Out-of-position - When welding out-of-position it is best to use a shielding gas of 100% CO₂ at 18-22 L/min and DC Straight Polarity. Welding should proceed vertical-down with 25mm wide weave beads.

Packaging Options

Diameter	Standard Packaging
1.6mm	11.4 kg spool

Diam.	11.4 kg Spool
1.6mm	PHFMANG-O16

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