POSTALLOY® 50

HARDFACE TECHNOLOGIES
by POSTLE INDUSTRIES

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Description

POSTALLOY® 50 is a unique new electrode that uses state of the art coating technology to produce maximum welding performance on all grades of cast iron and cast iron to steel including stainless. POSTALLOY® 50 offers the following important benefits.
- Dense Deposits on Dirty, Oil-Soaked Cast Iron
- Non-Conductive coating eliminates dangerous side-arcing
- Electrodes resist overheating reducing stub loss
- Low amperage minimizes heat rise in the casting POSTALLOY® 50 offers maximum crack resistivity due to its ideal combination of strength and ductility, and its high tolerance for harmful contaminants, such as sulfur and phosphorus. It has superior arc-purging action that penetrates through surface contamination, including contamination that has literally soaked into the casting, to produce a solid porosity-free deposit.

Specifications

Product Type: Electrode
Weld Deposit Properties
Tensile Strength   520 MPa
Hardness   200 BHN
Deposits are machinable

POSTALLOY® 50   Welding Parameters

Current: AC/DC Reverse (+)

Diameter	Amps
2.5mm	50-70
3.2mm	70-100

Welding Procedure
Vee out cracks and defective weld metal using POSTALLOY 250 gouging electrode. When using POSTALLOY 50, 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

Diam.	4.54 kg Pack
3.2mm	PHF5032