

POSTLE INDUSTRIES, INC.

P.O. Box 42037 • Cleveland, Ohio 44142

Fax: 216-265-9030 • Phone: 216-265-9000 • Toll Free: 800-321-2978

E-Mail: sparky@postle.com • Web Site: www.postle.com



Data Sheet

POSTALLOY® 215HD

Description

POSTALLOY 215HD hardfacing electrodes, available in 1/4"(6.0mm) and 1/2"(12.5mm), 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 deposit chemistries consist of chromium carbides combined in such a way as to produce extremely good abrasion resistance coupled with mild to moderate impact resistance. Deposits take on a high polish to resist sliding particle abrasion and will maintain good hot hardness up to 1000°F (538°C).

Due to its unique tubular design, **POSTALLOY 215HD** offers very smooth operational characteristics. Both the 1/4" and 1/2" diameters will fit standard electrode holders. Other outstanding features are:

- Easy out-of-position weldability with the 1/4" diameter.
- Excellent AC or DC operation, even on a "buzz box".
- High metal recovery - no slag to chip. **POSTALLOY 215HD** is over 90% efficient..
- Low amperage - 1/4"(6.0mm) from 80 amps, 1/2"(12.5mm) from 180 amps.
- High deposition rates - up to 3 times faster than ordinary electrodes.
- Moisture resistant coating, even under severe weather or high humidity.

Specifications

- Hardness.....58 - 62 Rc
- Deposit Thickness2 - 3 passes
- Relief checks readily to prevent stress build-up.
- Cannot be flame cut.

Applications

Mining, Quarrying and construction
Equipment
Clamshell and dragline buckets
Bucket lips and teeth
Scraper and grader blades
Dozer end bits
Chutes, liner plates
Dragline chains
Mixer blades

Screw conveyors
Dredge bucket lips
Suction dredge cutter teeth
Grizzly bars
Excellent final layer on manganese jaw crushers and swing hammers.
The 1/4" size is ideal for vertical, edge and stringer beads.
The 1/2" size is ideal for covering large areas and button hardfacing.

Welding Procedure: AC or DC Reverse Polarity.

Remove old hardfacing and any fatigued base metal. **POSTALLOY 250** gouging electrode is useful for this purpose. Preheat from 200° to 400°F (93° - 204°C) is recommended for steels with a carbon content of .25 to .45. Steels with a higher carbon level should be preheated from 400° to 700°F (204° - 371°C). Do not preheat austenitic manganese steel. The 1/4"(6.0mm) diameter can be used for vertical and flat position welding. The 1/2"(12.5mm) should be used for flat only. Use a minimum arc length equal to about the diameter of the electrode. Hold the electrode at 90° to the work surface for proper application. Do not apply more than two layers. On manganese or hardened steel, an intermediate or cushion layer of **POSTALLOY 207** is recommended.

DIAMETER: 1/4"(6.0MM)
AMPERAGES: 80 - 120

1/2"(12.5MM)
180 - 425