

POSTALLOY® 215HD

Data Sheet



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Description

POSTALLOY® 215HD hardfacing is a unique concept in hardfacing technology. It is tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes. Due to its unique tubular design, POSTALLOY® 215HD offers very smooth operational characteristics and is over 90% efficient. Both the 1/4" and 1/2" diameters will fit standard electrode holders. Other outstanding features include:

- 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
 - 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
- 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).

Specifications

Product Type: Electrode

Weld Deposit Properties

Hardness	58 - 62 Rc
Deposit Thickness	2 - 3 passes
Relief checks readily to prevent stress buildup.	
Cannot be flame cut.	

Applications

Mining and construction screw conveyors	Final layer on manganese jaw crushers and swing hammers
Equipment Dredge bucket lips	Dozer end bits
Clamshell and dragline buckets	Chutes, liner plates
Suction dredge cutter teeth	1/4" size is ideal stringer beads.
Bucket lips and teeth	1/2" size is ideal for hardfacing large areas
Grizzly bars	Dragline chains
Scraper and grader blades	
Mixer blades	

POSTALLOY® 215HD Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
1/4"(6.0mm)	80 - 120
1/2"(12.5mm)	180 - 425

Packaging Options

Diameter	Standard Packaging
1/4"(6.0mm)	Resealable Plastic Box
1/2"(12.5mm)	Resealable Plastic Box

