

**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 Thickness .....2 - 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
- Chutes, liner plates
- Dragline chains
- Mixer blades
- Screw conveyors
- Dredge bucket lips
- Suction dredge cutter teeth
- Grizzly bars

**WELDING PROCEDURES (POLARITY - AC OR DC STRAIGHT )**

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.

Size	1/4” (6mm)	1/2 (12.5mm)
Amperage	80-120	180-425