

DESCRIPTION

POSTALLOY® 2826-SPL is a martensitic tool steel type alloy with numerous tightly packed carbides for excellent abrasion resistance under high impact. Deposits are smooth and free of any slag. One layer deposits exhibit wear characteristics that you would expect from chromium carbide hardfacing products. An excellent choice for applications requiring crack free deposits with good wear characteristics.

SPECIFICATIONS

Wire Type: Metal-cored, Gas-shielded
Deposits are slag-free

Weld Deposit Properties:

Hardness: 55-58 Rc

Maximum Deposit Thickness: Unlimited with proper weld procedures. Non-machinable, must be ground.

APPLICATIONS

- Tool joints
- Hammers
- Drill Stabilizers
- Dredge buckets/teeth
- Agricultural implements
- Quarry and mine equipment
- Forestry gear
- De-barker knives

WELDING PARAMETERS (POLARITY - DC STRAIGHT)

Diameter	.045"(1.2mm)	1/16"(1.6mm)
Current <i>amps</i>	125-225	160-300
Voltage (<i>DCSP</i>) <i>volts</i>	20-26v	26-32v
Stickout <i>inch (mm)</i>	1/2"-1"(12-25mm)	3/4" - 1 1/4" (19-32mm)
Gas Flow <i>cfh (l/min)</i>	25-30 (12-15 l/min)	30-35 (14-17 l/min)
Gas	98%Ar / 2%Ox	98%Ar / 2%Ox
Preheat °C	150-232°C	165-232°C

Max interpass temperature of 370°C and post weld treat with a slow cool to room temperature.

PACKAGING

Diameter	.045"(1.2mm)	1/16"(1.6mm)
25 Lb. Spools	Standard	Standard
55 Lb. Coils	NA	Available