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Postalloy® DuraMang™ 2865-FCO is a flux-cored, open-arc hardfacing wire that deposits fully austenitic chromium-manganese weld metal. It can be used equally well for joining and build-up/surfacing of carbon, low alloy and manganese steels. Weld deposits have an excellent combination of weld metal strength, ductility and hardness. Work-hardens rapidly under repeated impact. Deposits have very good frictional wear properties and are ideal for railroad applications requiring metal-to-metal wear resistance. Ideal as a cushioning or buffer layer on manganese steel parts that will be repeatedly rebuilt. Since it will not embrittle until 1000°F (538°C), it will act as an insulator to the manganese base metal in helping it keep below 500°F (260°C) during the welding operation.

Specifications

Product Type

Wire: Flux-cored, Open-arc
Electrode equivalent: Postalloy® 207

Weld Deposit Properties

Tensile Strength: 122,000 psi
Yield Strength: 80,000 psi
Elongation: 40%
Hardness as deposited: 20Rc
Work hardens in service to: 45-55Rc
Machinability: Poor
Deposits cannot be flame-cut

Applications

Pulverizing hammers	Cone and roll shells
Gyratory crusher mantles	Grizzly bars
Dragline and power shovel bucket lips and teeth	Hammer mill hammers
Crusher rolls and jaws	Steel mill wobblers
Sizing screens	

Postalloy® DuraMang™ 2865-FCO Welding Parameters

Current: DC Electrode Positive and Globular Metal Transfer

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	100-175	24-28	1"(25mm)
1/16" (1.6mm)	150-250	26-29	1"-1¼"(25-32mm)
7/64" (2.8mm)	300-450	24-28	1¼"-1½"(32-38mm)

Packaging Options

Diameter	Standard Packaging	Available Packaging
.045" (1.1mm)	25 lb spool	110 lb drum, 220 lb drum
1/16" (1.6mm)	25 lb spool	55 lb coil, 110 lb drum, 220 lb drum
7/64" (2.8mm)	55 lb coil, 110 lb drum, 220 lb drum	

