

Postle Industries • Cleveland, OH USA • Telephone: 216-265-9000 • Fax: 216-265-9030

Abrasion resistant Postalloy® DuraHard™ 2898-MCG is a general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. DuraHard™ 2898-MCG is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100°F (593°C). For maximum impact resistance and to avoid cracking in multi-layer deposits, a preheat of 550°F (288°C) is recommended. Use to overlay carbon, low alloy steel and manganese steel.

Specifications

Product Type

Wire: Metal-cored, gas-shielded

Deposits are slag-free.

Gases: Ar/CO, Ar/Ox.

Also available as a flux-cored, open-arc wire - Postalloy® DuraHard™ 2898-FCO

Electrode equivalent: Postalloy® 21

Weld Deposit Properties

Average Hardness: 55-59Rc

Good Hot-hardness: Up to 1100° F (593°C)

Maximum overlay: Unlimited layers with proper procedures, including preheat and interpass temperature

Non-Machinable: Must be ground

Applications

Dragline buckets, teeth and lips

Tillage tools

Conveyor screws

Bulldozer blades and end bits

Tamper feet

Bucket Teeth

Farm Implements

Augers

Postalloy® DuraHard™ 2898-MCG Welding Parameters

Current: DC Reverse Polarity

Short Arc	Amps	Volts	Stick Out
.035" (0.9mm)	70-190	15-21	1/2"(12mm)
.045" (1.1mm)	90-120	15-21	1/2"(12mm)
1/16" (1.6mm)	150-220	18-21	3/4"(19mm)
Spray Arc	Amps	Volts	Stick Out
.035" (0.9mm)	230-300	20-27	1/2"(12mm)
.045" (1.1mm)	250-325	27-30	5/8"(15mm)
1/16" (1.6mm)	300-375	27-30	3/4"(19mm)

Packaging Options

Diameter Standard Packaging

.035" (0.9mm)	25 lb spool
.045" (1.1mm)	25 lb spool
1/16" (1.6mm)	25 lb spool

Available Packaging

50 lb spool, 110 lb drum, 220 lb drum
50 lb spool, 55 lb coil, 110 lb drum, 220 lb drum

