

POSTALLOY® 2898-SPL (650-G)



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Description

A general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. POSTALLOY® 2898-SPL is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 600°C.

Specifications

Product Type: Metal-cored, gas-shielded

Deposits are slag-free.

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

Weld Deposit Properties

Average Hardness: 55 -59 HRc

Good Hot-hardness: up to 600°C

Maximum overlay: 2 - 3 layers

Non-Machinable: must be ground

Applications

Hot Shear Blades Dozer Blades

Shearing and piercing dies

Bucket Teeth

Farm Implements Augers

POSTALLOY® 2898-SPL Welding Parameters

Current: DC Reverse Polarity

Short Arc	Amps	Volts	Gas	L/min	Stick Out
1.2mm	90-200	15-21	Ar/CO2	12-15	12mm
1.6mm	150-220	18-21	Ar/CO2	12-15	18mm
Spray Arc	Amps	Volts	Gas	L/min	Stick Out
1.2mm	250-325	27-30	Ar/Ox	18-22	15mm
1.6mm	300-375	27-30	Ar/Ox	18-22	18mm
Pulsed Spray Arc	Current	Peak Amps	Volts	L/min	Stick Out
1.2mm	200/220/250	350/375/425	24/25/26	18-22	15mm
1.6mm	250/275/300	350/375/400	24/25/26	18-22	18mm

Packaging Options

Diameter	Standard Packaging
1.2mm	11.4kg spool and 4.54 kg spool
1.6mm	11.4kg spool