

POSTLE INDUSTRIES, INC.



P.O. Box 42037 • Cleveland, Ohio 44142

Fax: 216-265-9030 • Phone: 216-265-9000 • Toll Free: 800-321-2978

E-Mail: sparky@postle.com • Web Site: www.postle.com

Data Sheet

POSTALLOY® 2892-SPL

Description

Medium hardness build-up wire with excellent compressive strength. Recommended for applications where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as welded". Use on carbon and low alloy steels.

Specifications

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

Weld Deposit Properties:

Hardness: 33 - 38 Rc
Maximum Deposit Thickness: Unlimited
Deposits can be flame cut
Machinable with carbide tools

Applications

Machine components	Gear teeth
Steel mill parts	Keyways
Undercarriage	Carbon steel railroad track components
Parts of earth moving and mining equipment	

Welding Parameters - Use DC Reverse Polarity

	SHORT-ARC		SPRAY-ARC		PULSED SPRAY ARC WELDING						
	.045	1/16	.045	1/16	Use 98/2 Argon/Oxygen with 120pps						
Amps	90-200	150-220	250-325	300-375	Current	200	220	250	250	275	300
Volts	15-21	18-21	27-30	27-30	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO2	Ar/CO2	Ar/Ox	Ar/Ox	Volts	24	25	26	24	25	26
CFH	25-30	25-30	40-45	40-45	CFH	40-45			40-45		
Stick-out	1/2"(12mm)	3/4"(18mm)	5/8"(15mm)	3/4"(18mm)	Stick-out	5/8"(15mm)			3/4"(18mm)		

When welding out-of-position, use the lower ranges of voltages and amperages: 16 - 19 volts and 100 - 150 amps.

Packaging

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

Also available as a flux-cored, open-arc wire - **Postalloy 2892-FCO**
Alternative Welding Electrode - **Postalloy 27**