

Data Sheet

DESCRIPTION

POSTALLOY® 2836-SPL is a high hardness multi-carbide hardfacing alloy that resists severe abrasion, including high stress grinding, low stress scratching and gouging abrasion. It maintains its hardness and wear resistance up to 1400°F (760°C). The chemistry is highly tolerant of dilution. One layer will easily outwear two layers of ordinary chrome carbides and in some applications the wear is equal to tungsten carbide.

SPECIFICATIONS

Wire Type: Metal-cored, Open-arc or gas shielded
Deposits are slag free

Weld Deposit Properties:

Average Hardness: 63 - 67 Rc

Deposit thickness: 1-2 layers

Deposits cannot be flame cut

Deposits will readily relief check-crack

APPLICATIONS

- Blast furnace charging equipment
- Sinter plant parts
- Coke pusher shoes
- Coke crusher segments
- Tong bits
- Slag ladles
- Ash fans
- Solid waste shredder parts
- Agricultural implements
- Cement mill parts
- Brick making equipment
- Cereal grinding equipment
- Conveyor screws
- Mixer paddles
- Wear bars
- Wear plates

WELDING PARAMETERS (POLARITY - DC STRAIGHT OR REVERSE)

Diameter	.045"(1.2mm)	1/16"(1.6mm)	7/64"(2.8mm)
Current <i>amps</i>	100-225	160-300	250-400
Voltage (DCSP) <i>volts</i>	15-26v	20-28v	24-30v
Stickout <i>inch (mm)</i>	3/4"1 1/4"(18-30mm)	1"-1 1/2"(25-38mm)	1 1/2"(38mm)
Gas Flow <i>cfh (l/min)</i>	NA	NA	NA

While all sizes of **POSTALLOY® 2836-SPL** will easily operate with or without a gas cover, you may find applications for .045 and 1/16 for which you prefer a shielding gas. If a gas cover is used, Argon/CO₂ or 100% CO₂ is recommended. This will cause amperages to go up by about 10% and the stick-out should be shortened. When welding out of position, use the lower range of amperages and voltages. In addition, a gas cover may be useful, especially when using a constant current power source and voltage sensing feeder.

PACKAGING

Diameter	.045"(1.2mm)	1/16"(1.6mm)	7/64"(2.8mm)
25 Lb. Spools	Standard	Available	NA
55 Lb. Coils	NA	Available	Standard
110,220 Lb. Drums	Available	Available	Standard