PROLINE
professional welding supplies

POSTALLOY® 2898-SPL

DESCRIPTION

POSTALLOY® 2898-SPL is 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 1100OF(595OC)

APPLICATIONS

- Hot Shear Blades
- Dozer Blades
- Shearing and piercing dies
- Bucket Teeth
- Agriculture Implements
- Augers
- Forrestry Handling Grapples
- Drilling tools
- Hot Guides and rolles

SPECIFICATIONS

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

Weld Deposit Properties:
Average Hardness: 55 – 59 Rc
Good Hot-hardness: up to 1100° F(595OC)
Maximum overlay: 2 – 3 layers

WELDING PARAMETERS (POLARITY - DC STRAIGHT)

	SHORT- ARC			SPRAY-ARC		
Diameter	**.035"(0.9mm)**	**.045"(1.2mm)**	**1/16"(1.6mm)**	**.035"(0.9mm)**	**.045"(1.2mm)**	**1/16"(1.6mm)**
Current *amps*	90-140	125-225	125-375	120-190	250-325	300-375
Voltage (DCSP)	15-23v	20-26v	23-28v	24-28v	27-30v	27-30v
Gas	Ar/Co2	Ar/Co2	Ar/Co2	Ar/Ox	Ar/Ox	Ar/Ox
Gas Flow *cfh (l/min)*	25-30 (12-15l/min)	25-30 (12-15l/min)	25-30 (12-15l/min)	40-45 (19-22 l/min)	40-45 (19-22 l/min)	40-45 (19-22 l/min)
Stickout *inch (mm)*	1/2"-1"(12-25mm)	1/2"-1"(12-25mm)	1"-1½"(25-38mm)	5/8"(15mm)	5/8"(15mm)	3/4"(18mm)

	PULSED SPRAY ARC WELDING (Use 98/2 Argon/Oxygen with 120pps)					
Diameter	**.045"(1.2mm)**			**1/16"(1.6mm)**		
Current *amps*	200	220	250	250	275	300
Peak Amps	350	375	425	350	375	400
Voltage (DCSP) *volts*	24v	25v	26v	24v	25v	26v
Gas Flow *cfh (l/min)*	40-45 (19-22 l/min)			40 - 45 (19-22 l/min)		
Stickout *inch (mm)*	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	0.35"(0.9mm)	.045"(1.2mm)	1/16"(1.6mm)	7/64"(2.8mm)
25 Lb. Spools	Standard	Available	Standard	NA
33 Lb. Spools	Available	Standard	Available	NA
55 Lb. Coils	NA	NA	Available	Standard

Ph: 0800 699 353
sales@prolinewelding.com