

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

Postalloy® 14TC is a self-fluxing, oxy-acetylene hardfacing alloy with Tungsten Carbide added that is applied below the fusion temperature of the base metal. It may be used on carbon steels, alloy steels, nickel alloys, stainless steels, duplex stainless steel and cast iron. Postalloy® 14TC flows out easily and may be applied in extremely thin layers. Deposits are non-sparking, non-magnetic, and non-heat treatable. Benefits of Postalloy® 14TC include:

- Excellent cold and hot abrasion resistance - Postalloy® 14TC maintains a high level of hardness up to 1200°F (649°C)
- Outstanding for metal-to-metal wear resistance - Deposits take on an extremely high polish, and will resist galling and freezing when in contact with other metals.
- Good Corrosion Resistance - Postalloy® 14TC will provide corrosion protection that is equal to most stainless steels and Inconel alloys.

## Specifications

### Product Type

Oxy-acetylene

Available with additions of tungsten carbide blended into the matrix - Postalloy® 14TC.

Also available as a semi-automatic wire - Postalloy® 2814-SPL.

### Weld Deposit Properties

Hardness: 59Rc

Hardness at 800°F (427°C): 55Rc

Hardness at 1000°F (538°C): 50Rc

Hardness at 1200°F (649°C): 45Rc

## Applications

Cement and paper pulp mixing blades

Pistons

Forming dies and wire drawing dies

Overlaying edges of augers

Industrial knives

Screws

## Postalloy® 14TC Welding Parameters

Current: Current:

### Diameter

3/32" (2.4mm)

1/8" (3.1mm)

3/16" (4.8mm)

Welding Procedure

Oxy-Acetylene

Clean weld area and grind rough edges smooth. Self-fluxing on most applications. For difficult base metals use Postalloy® 91-D (dry) FLUX on areas to be overlayed. On cast iron use with Postalloy® 54 FLUX. Heat with oxy-acetylene torch using a neutral flame. When a dull red color is reached, begin applying alloy. Avoid overheating. On certain high alloyed metals use a slightly carburizing flame to increase fluidity. Cool slowly. Grind to shape..

## Packaging Options

### Diameter      Standard Packaging

3/32" (2.4mm)      Resealable Plastic Box

1/8" (3.1mm)      Resealable Plastic Box

3/16" (4.8mm)      Resealable Plastic Box

