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Postalloy® 206HD is a high chromium-nickel-moly alloy electrode that produces deposits with excellent strength and elongation, combined with a high degree of toughness. Weld deposits work-harden in service and provide outstanding impact resistance. The austenitic structure of the weld deposit provides very good corrosion resistance. It's versatility allows it to be used for joining, as well as a cushion layer prior to hardfacing with a harder, more wear resistant alloy. Use on carbon and alloy steels, stainless and joining dissimilar combinations.

Specifications

Product Type

Flux-coated Electrode: High chromium-nickel-moly alloy electrode
Also available as a semi-automatic wire - Postalloy® 2866-FCO.

Weld Deposit Properties

Tensile Strength: 100,000 psi
Yield Strength: 78,000 psi
Elongation: 25%
Hardness as deposited: 100-150Rb
Work hardens in service to: 30-35Rc
Deposits cannot be flame-cut
Deposits are machinable

Applications

Rebuilding under carriage components
Impactors
Sprockets
Weld in wear plate

Gear teeth
Cushion layer for hardfacing alloys
Sheaves

Postalloy® 206HD Welding Parameters

Current: AC or DC Reverse

Diameter	Amps
1/8" (3.1mm)	90-130
5/32" (4.0mm)	125-160
3/16" (4.8mm)	150-225

Welding Procedure

Clean weld area. Maintain a short to medium arc. Direct the arc on deposited weld metal depositing 3 to 4 inches at a time (75mm-100mm). Skip welding is advisable on large parts. Peening while hot helps shape the deposit and reduce stress. Cool slowly.

Packaging Options

Diameter	Standard Packaging
1/8" (3.1mm)	Resealable Plastic Box
5/32" (4.0mm)	Resealable Plastic Box
3/16" (4.8mm)	Resealable Plastic Box

