Postalloy® 218HD Data Sheet

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Postalloy® 218HD produces a multi-carbide weld deposit that resists many types of wear. The weld-deposit. is a tightly packed, dense, inter-connected network of chromium carbides, vanadium carbides, molybdenum carbides, niobium carbides and tungsten carbides. Weld deposits offer exceptional wear resistance to general abrasion, high stress grinding, low stress scratching and erosion. Impact resistance is limited. This alloy may also be used at elevated temperatures up to1500°F (816°C). First pass hardness is greater than other hardface electrodes - 65Rc on mild steel. Other outstanding features include:

- Excellent AC or DC operation
- Low amperage and high metal recovery - no slag to chip
- High deposition rates - up to 3 times faster than ordinary electrodes
- Moisture resistant coating, even under severe weather or high humidity

Sinter Breaker

Specifications

Product Type

Flux-coated Tubular Electrode

Weld Deposit Properties

Hardness: 65Rc
Heat Resistance: Excellent up to 1500°F (816°C)
Deposit Thickness: 2 layers
Weld deposits will relief check-crack readily

Applications

Solid waste shredder parts
Agricultural implements
Earth moving and construction equipment
Cement mill parts
Brick making equipment
Cereal grinding equipment and muller plows

Postalloy® 218HD Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
1/4" (6.0mm)	80-130
3/8" (9mm)	130-180
1/2" (12mm)	180-220

Welding Procedure
Remove old hardfacing and any fatigued base metal. Postalloy® 250 gouging electrode is useful for this purpose. Preheat from 200-400°F (93-204°C) is recommended for steels with a carbon content of .25 to .45. Steels with a higher carbon level should be preheated from 400-700°F (204-371°C). Do not preheat austenitic manganese steel. Use a minimum arc length equal to about the diameter of the electrode. Hold the electrode at 90° to the work surface for proper application. Do not apply more than two layers. On manganese or hardened steel, an intermediate or cushion layer of Postalloy® 207 is recommended.

Packaging Options

Diameter	Standard Packaging
1/4" (6.0mm)	Resealable Plastic Box
3/8" (9mm)	Resealable Plastic Box
1/2" (12mm)	Resealable Plastic Box