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Postalloy® 2521-B is a cobalt base hardfacing alloy offering good strength and toughness at elevated temperatures up to 1500°F(816°C), and is used for weld overlaying of hot-working dies and valves. A low carbon content weld deposit with dispersed hard carbides provide excellent resistance to thermal shock, galling, corrosion, and cavitation erosion. These deposits are strengthened by the addition of molybdenum and are very stable in thermal cycling environments.

- Weld deposits exhibit superior resistance to heat checking, spalling and chipping.
- Excellent resistance to corrosive environments, and outstanding resistance to cavitation, erosion and thermal shock.
- Resists oxidizing and reducing atmospheres up to 2100°F(1149°C).
- Postalloy®2521-B also provides excellent resistance to corrosive environments.

Specifications

Product Type

Bare Rod: Cobalt base hardfacing alloy for TIG or Oxy-acetylene

Weld Deposit Properties

Deposit thickness: 2 Layers

Hardness as welded: 30-35Rc

Work hardens over: 40Rc

Deposits have very little tendency to relief check and are fully machinable

Applications

Forging dies, Hot trimming dies, Hot shears, Cavitation repair, chemical and petrochemical valves, Forging dies, Steam and fluid control valve bodies and Seamless pipe piercing mandrels.

Postalloy® 2521-B Welding Parameters

Current: DCEN

TIG	Amps	Volts	Gas
.045" (1.1mm)	50-80	15-25	100% Ar
1/16" (1.6mm)	55-90	15-25	100% Ar
3/32" (2.4mm)	75-100	15-25	100% Ar
1/8" (3.1mm)	90-120	15-30	100% Ar
5/32" (4.0mm)	120-140	15-30	100% Ar
3/16" (4.8mm)	140-160	15-30	100% Ar
Oxyacetylene	Tip Size	Flame	
.045" (1.1mm)	3	3x-4x	
1/16" (1.6mm)	3-4	3x-4x	
3/32" (2.4mm)	3-4	3x-4x	
1/8" (3.1mm)	4	3x-4x	
5/32" (4.0mm)	4	3x-4x	
3/16" (4.8mm)	5	3x-4x	

Packaging Options

Diameter	Standard Packaging
All Diameters	10 lb tubes

