

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

Postalloy® 27 is a non-cracking build-up electrode in the machinable range of hardness providing wear resistance that is far superior to low and medium carbon steel and low alloy steels. Deposits are extremely tough and have a high resistance to impact and deformation and are not subject to spalling or roll-over. In addition, deposits are dense, crack-free and porosity-free.

Specifications

Product Type

Flux-coated electrode

Alternative Wire: Postalloy® 2892-FCO, Postalloy® 2892-SPL

Weld Deposit Properties

Hardness: up to 31Rc

Deposit Thickness: As required

Impact Resistance: Excellent

Compressive Strength: High

Abrasion Resistance: Fair

Can be flame-cut

Applications

Rebuilding badly worn machine parts back to original dimensions

Roll ends

Shafts

Buildup of parts prior to overlaying with a more resistant overlay

Brake drums

Wheels

Tractor rolls

Rails

Idlers

Gear teeth

Wobblers

Sprockets

Dredge pump casing

Trunnions

wear

Postalloy® 27 Welding Parameters

Current: AC/DC Reverse

Diameter	Amps
1/8" (3.1mm)	90-120
5/32" (4.0mm)	120-150
3/16" (4.8mm)	160-180

Welding Procedure

Clean weld area. Use of Postalloy 250 is recommended to remove fatigued or damaged metal. Preheat heavy sections to about 250°F (121°C). Use stringer or weaving technique holding a short to medium arc. Long deposits may be made without danger of cracking. Do not allow excessive heat buildup. Chip slag between passes. Allow part to 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

