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Postalloy® DuraForge™ 2756-FCG is a modified 5% chrome-tungsten-moly-vanadium enriched welding alloy. Due to additional moly and vanadium, DuraForge™ 2756-FCG is more wear resistant than Postalloy® DuraForge™ 2755-FCG. Used to upgrade standard AISI H-12 hot-working tool steels. Water spray coolants should be avoided.

Typical Applications:

Primarily used to repair and rebuild flash lines on press forging dies and is also used to overlay shallow impression dies. Use Postalloy® DuraForge™ 2747-FCG as an intermediate build-up on deeper impressions. A 3/8" overlay would be the maximum.

Specifications

Product Type

Wire: Flux-cored, Gas-Shielded (with an easily removed slag covering)

Weld Deposit Properties

Average Hardness: 53-57Rc

Heat Treatment: use H-12 Procedure

Applications

See above

Postalloy® DuraForge™ 2756-FCG Welding Parameters

Current: DC Electrode Positive

Diameter	Amps	Volts	Stick Out
1/16" (1.6mm)	300-310	30-31	3/4" (19mm)
3/32" (2.4mm)	250-450	26-32	1 1/4" (32mm)
1/8" (3.1mm)	450-750	30-38	1 1/2" (38mm)

Welding Procedure

Shielding Gas: 75/25 Argon/CO₂, 80/20 Argon/CO₂, 90/10 Argon/CO₂, 92/8 Argon/CO₂. Slow Cooling after welding is extremely important to reduce stress build-up and minimize the risk of cracking. Therefore, using this wire requires a minimum of preheat from 600°F to 800°F (315°C to 427°C) depending on size of the part and composition of the base metal. Throughout welding operation, limit interpass temperature to 900°F (480°C). After welding, the part should be returned to the preheat furnace to allow the temperature throughout the part to equalize.

Packaging Options

Diameter	Standard Packaging	Available Packaging
1/16" (1.6mm)	33 lb spool	55 lb coil
3/32" (2.4mm)	55 lb coil	

