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Postalloy® 2803-FCG is a flux-cored, nickel base alloy designed for hot-working applications such as rotary dies and flat open face dies. Postalloy® 2803-FCG is alloyed with chromium, molybdenum, tungsten and cobalt to withstand stresses and oxidation at elevated temperatures up to 2000°F (1100°C). Postalloy® 2802-FCG is recommended as an underlay.

## Specifications

### Product Type

Wire: Flux-cored, gas-shielded

### Weld Deposit Properties

Hardness as deposited : 20-25 Rc

Work-hardens: up to 35 Rc

## Applications

Forging Dies

## Postalloy® 2803-FCG Welding Parameters

Current: DC Reverse Polarity

Diameter	Amps	Volts	Stick Out
1/16" (1.6mm)	225-275	18-22	5/8"(15 mm)

Welding Procedure

Use DC Reverse Polarity. Gas Coverage - 75% Argon / 25% CO<sub>2</sub>

## Packaging Options

Diameter	Standard Packaging	Available Packaging
1/16" (1.6mm)	25 lb spool	25 lb spool

