

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

Postalloy® DuraHard™ 2828NCTi-FCO is a non-cracking flux-cored, open-arc hardfacing wire that deposits a martensitic alloy with a high volume of finely dispersed Titanium Carbides (TiC). It has excellent abrasion resistance under low and high stress conditions and retains hardness at high temperatures. Crack-free deposits are possible with proper procedures. Use on carbon and low alloy steels.

- Excellent welding characteristics..
- Multiple layers maintain their hardness and abrasion resistance..
- Produces full slag coverage that does not require removal between passes. Slag is easily removed with a chipping hammer.
- Deposits are crack-free even after multiple layers.

## Specifications

### Product Type

Wire: Flux-cored, open-arc

**\*\*RCT™ Reactive Core Technology** improves weldability and optimizes wear properties. [Learn more.](#)

### Weld Deposit Properties

Average Hardness: 57-60Rc

Good Hot-hardness: up to 1100° F (593°C)

Maximum overlay : Unlimited layers with proper procedures, including preheat and interpass temperatures

Non-Machinable: Must be ground

Cannot be flame-cut

## Applications

Cement rolls

Hardbanding drill pipes

Hammers

Bucket pins

Shredder & Fibrizer hammers

Bucket teeth and lips

Tillage implements

Augers

Asphalt mixer paddles

## Postalloy® DuraHard™ 2828NCTi-FCO Welding Parameters

Current: Use DC Electrode Positive

Diameter	Amps	Volts	Stick Out
3/32" (2.4mm)	280-340	26-30	1"-1½"(25-38mm)
1/16" (1.6mm)	210-250	26-29	1"- 1 1/4 " (25-32mm)
7/64" (2.8mm)	325-500	26-30	1"- 1 1/2 " (25-38mm)

Welding Procedure

Out of position welding is limited to horizontal stringers. Preheats and Inter-pass temperatures should be based on base metal chemistry.

## Packaging Options

### Diameter Standard Packaging

3/32" (2.4mm) 55 lb spool

7/64" (2.8mm) 55 lb spool

1/16" (1.6mm) 25 lb spool

