Postalloy® 2836-MCO Data Sheet

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Postalloy® 2836-MCO is a high hardness multi-carbide hardfacing alloy that resists severe abrasion, including high stress grinding, low stress scratching and gouging abrasion. It maintains its hardness and wear resistance up to 1300°F (700°C). The chemistry is highly tolerant of dilution. One layer will easily outwear two layers of ordinary chrome carbides and in some applications the wear is equal to tungsten carbide. Use on low carbon mild steel, manganese, stainless, and low alloy steels.

Bucket Teeth

Specifications

Product Type

Wire: Metal-cored, open arc or gas-shielded. Deposits are slag-free.
Electrode equivalent: Postalloy® 218HD

Weld Deposit Properties

Hardness: 63-67Rc
Deposit Thickness: 1-2 layers
Cannot be flame-cut
Deposit will readily relief check-crack

Applications

Blast furnace charging equipment
Agricultural implements
Sinter plant parts
Cement mill parts
Coke pusher shoes
Brick making equipment
Wear plates
Cereal grinding equipment
Tong bits
Conveyor screws
Slag ladles
Mixer paddles
Ash fans
Solid waste shredder parts

Postalloy® 2836-MCO Welding Parameters

Current: DC Electrode Positive or DC Electrode Negative

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	100-225	15-26	3/4"-1"(19-25mm)
1/16" (1.6mm)	160-300	20-28	1"-1½ "(25-38mm)
3/32" (2.4mm)	230-400	28-30	1"-1¼"(25-32mm)
7/64" (2.8mm)	250-400	28-32	1½ (38mm)

Welding Procedure

While all sizes of Postalloy 2836-MCO will easily operate with or without a gas cover, you may find applications for .045 and 1/16 for which you prefer a shielding gas. If a gas cover is used, Argon/CO_2 or 100% CO_2 is recommended. This will cause amperages to go up by about 10% and the stick-out should be shortened. When welding out of position, use the lower range of amperages and voltages. In addition, a gas cover maybe useful, especially when using a constant current power source and voltage sensing feeder.

Packaging Options

Diameter	Standard Packaging	Available Packaging
.045" (1.1mm)	25 lb spool	110 lb drum, 220 lb drum
1/16" (1.6mm)	25 lb spool	55 lb coil, 110 lb drum, 220 lb drum
3/32" (2.4mm)	55 lb coil, 110 lb drum, 220 lb drum	
7/64" (2.8mm)	55 lb coil, 110 lb drum, 220 lb drum	

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