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Postalloy® DuraBuild™ 2866-FCO is a flux-cored, open-arc high chromium-nickel-moly alloy that produces deposits with excellent strength combined with a high degree of toughness. Fully austenitic weld deposits are especially suited for building-up or buffer layers before hardfacing with a more abrasion resistant alloy. Weld deposits work-harden in service and provide outstanding impact resistance. The austenitic structure of the weld deposit provides very good corrosion resistance as well as good scale resistance up to 1600°F (870°C). It's versatility allows it to be used for joining, as well as a cushion layer prior to hardfacing with a harder, more wear resistant alloy. Use on carbon and alloy steels, stainless and manganese steels and joining dissimilar combinations.

Specifications

Product Type

Wire: Flux-cored, Open-arc
Electrode equivalent: Postalloy® 206HD

Weld Deposit Properties

Tensile Strength: 100,000 psi
Yield Strength: 78,000 psi
Elongation: 25%
Hardness as deposited: 100-150Rb
Work hardens in service to: 30-35Rc
Deposits cannot be flame-cut
Deposits are machinable

Applications

Steel mill rolls	Ingot buggy car wheels
Kiln trunnions	Dredge ladder rolls
Cable sheaves	Forging dies

Postalloy® DuraBuild™ 2866-FCO Welding Parameters

Current: DC Electrode Positive and Globular Metal Transfer

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	150-200	25-28	1" (25mm)
1/16" (1.6mm)	180-250	27-29	1"-1¼"(25-32mm)

Packaging Options

Diameter	Standard Packaging
.045" (1.1mm)	25 lb spool
1/16" (1.6mm)	25 lb spool

