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Postalloy® DuraForge™ 2871-MCG is a tough, shock resistant non-cracking tool steel hardfacing composition with good resistance to corrosion, metal-to-metal wear, and abrasion. Deposits polish in service to reduce friction and minimize wear of mating parts. Excellent resistance to heat-checking. Multi-layer, crack-free deposits can be obtained with proper procedures.

Specifications

Product Type

Wire: Metal-cored, Gas-shielded
Deposits are slag-free.

Weld Deposit Properties

Hardness: 46-50Rc
Machinable with carbide tools and good machining practices

Applications

Steel mill rolls
Cable sheaves
Dredge ladder rolls

Kiln trunnions
Ingot buggy car wheels
Forging Dies

Postalloy® DuraForge™ 2871-MCG Welding Parameters

Current: Use DC Electrode Positive

Short Arc	Amps	Volts	Stick Out
.045" (1.1mm)	90-200	15-21	1/2"(12mm)
Spray Arc	Amps	Volts	Stick Out
.045" (1.1mm)	250-325	27-30	5/8"(15mm)

Welding Procedure

Use 98/2 Argon/Oxygen with 120pps. When welding out-of-position, use the lower ranges of voltages and amperages: 16-19 volts and 100-150 amps.

Packaging Options

Diameter	Standard Packaging
.045" (1.1mm)	25 lb spool

