

# POSTLE INDUSTRIES, INC.



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## DataSheet

### Description

#### **POSTALLOY® Durahard™2898-FCG with Reactive Core Technology (RCT)**

**The BEST out of position hardface wire.** Postalloy® DuraHard™2898-FCG is a general purpose gas shielded flux core wire that gives superior resistance to wear in abrasion situations, even when combined with heavy impact. The Reactive Core Technology (RCT) makes it extremely easy to run in vertical applications. Deposits are smooth and dense and will greatly extend service life on a wide range of equipment and machinery. It has good metal to metal wear resistance and is very resistant to chipping and spalling.

### Specifications

**Wire Type:** Flux-cored, gas-shielded

**Weld Deposit Properties:**

Average Hardness: 53-57 Rc  
Good Hot-hardness: up to 1100°F(595°C)  
Non-Machinable: must be ground

### Applications

- Crusher Parts
- Ground Engaging Tools
- Hot Shear Blades
- Farm Implements
- Bucket teeth
- Dozer Blades
- Augers
- Shearing and piercing dies

### Welding Parameters - Use DC Reverse

	<b>.045</b>	<b>1/16</b>
Amps	150-250	200-300
Volts	21-26	23-28
Gas	CO <sub>2</sub>	CO <sub>2</sub>
Stick-out	1/2"-1"(12-24mm)	3/4"-11/2"(18-30mm)

When welding out-of-position, use the lower ranges of voltages and amperages: 16 - 19 volts and 135 - 150 amps.

### Packaging

**Diameter**  
33 lbs. Spools

**.045"(1.2mm)**  
Standard

**1/16"(1.6mm)**  
Standard

Also available as a flux-cored, open-arc wire **2898-FCO** and Alternative Welding Electrode - **Postalloy 21**