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Abrasion resistant. Postalloy® DuraHard™2898-FCO is a general purpose flux-cored, open-arc hardfacing wire providing a good combination of abrasion resistance and toughness. Use for metal-to-metal-to-earth wear applications. Use to overlay carbon and low alloy steel and manganese steel. Multiple layers can be applied with proper preheat and inter-pass temperature.

Specifications

Product Type

Wire: Flux-cored, Open-arc.

Also available as a metal-cored, gas-shielded wire - Postalloy® DuraHard™ 2898-MCG

Electrode equivalent: Postalloy® 21

Weld Deposit Properties

Hardness: 55-59Rc

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

Non-machinable: Must be ground

This alloy may relief check (depending on type of base metal, thickness, etc.)

Non-cracking with proper preheat and postheat temperatures.

Machinability - Best by grinding or machining with special tooling.

Applications

Tillage tools

Bulldozer blades and end bits

Conveyor screws

Dragline scrapers

Backhoe buckets

Dragline chain idlers

Clamshell buckets

Agitator bearings and shafts

Shovel and dragline bucket lips and teeth

Sprockets

Tractor grousers

Gudgeon hangers and pins

Postalloy® DuraHard™ 2898-FCO Welding Parameters

Current: DC Reverse Polarity and Globular Metal Transfer

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	100-200	21-27	3/4"-1¼"(19-32mm)
1/16" (1.6mm)	150-300	23-28	1"-1¼"(25-32mm)
7/64" (2.8mm)	325-500	25-30	1"-1½"(25-38mm)

Packaging Options

Diameter	Standard Packaging	Available Packaging
.045" (1.1mm)	25 lb spool	55 lb coil
1/16" (1.6mm)	25 lb spool	55 lb coil
7/64" (2.8mm)	55 lb coil	

