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Postalloy® BR5-SA is a low alloy tubular welding wire for submerged-arc welding. This alloy is designed specifically for brake rims on oilfield drilling rigs. Proper welding procedures, including proper preheat and postheat, should be followed to avoid circumferential cracks. Postalloy® BR5-SA is limited to four layers. For more than four layers an under base of Postalloy® 2891-SA should be used. Tungsten Carbide tools are required for machining.

## Specifications

### Product Type

Wire: Submerged-arc

### Weld Deposit Properties

Hardness: 44-47Rc

Deposit Layers: 3-4

Preheat may be required for certain low alloy, higher carbon steels

Machinable

## Applications

Oilfield brake rims

Rollers

Mine car wheels

Charging car wheels

Idlers

Arch wheels

Steel mill table rolls

## Postalloy® BR5-SA Welding Parameters

Current: DC Electrode Positive

| Diameter      | Amps    | Volts | Stick Out        |
|---------------|---------|-------|------------------|
| 5/32" (4.0mm) | 425-540 | 29-32 | 1¼"-1½"(33-38mm) |

Welding Procedure

Flux: Neutral

Position: Flat

## Packaging Options

| Diameter      | Standard Packaging       |
|---------------|--------------------------|
| 1/16" (1.6mm) | 55lbs. coil, 500 lb drum |

