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Postalloy® CF-27 is a high hardness, chromium-free metal-cored hardfacing overlay designed for high abrasion applications with minimal impact. The unique wear properties are derived from a network of Boron, Niobium, Vanadium and Molybdenum Carbides in a hard carbon/iron matrix. Abrasive wear properties are superior to traditional chromium carbide alloys of similar hardness - 60 to 65Rc. This alloy has excellent weldability without exposing the welder to harmful hexavalent chromium fumes with a very smooth bead with no slag to remove. Deposit efficiency over 90%. CF27 may be used with any common shielding gas or open-arc.

Caution - Even though most of the welding fume comes from the electrode/filler wire, some of the fume does come from the base metal being welded. Therefore, the base material should be checked for chromium content...

## Specifications

### Product Type

Wire: Metal-cored  
Gas shielding, 100% CO<sub>2</sub>, 75/25 or 98/2  
Also operates Open Arc

### Weld Deposit Properties

Matrix Hardness: 65Rc  
Maximum Thickness: 2 Layers  
Deposits are non-machinable  
Deposits will check-crack to relieve stress

## Applications

Shovel teeth	Cutter drums
Wear parts	Subsoiler teeth
Screw conveyors	Dozer blades
Longwall miners	Clamshell buckets

## Postalloy® CF-27 Welding Parameters

Current: DC Electrode Positive

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	100-200	18-22	1/2"(12mm)
1/16" (1.6mm)	150-200	20-25	3/4"(19mm)

## Packaging Options

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

