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## CHROMIUM FREE HARDFACING

Postalloy® CF-28 is a high hardness, Chromium free hardfacing overlay designed for high abrasion applications with minimal impact. The unique wear properties are derived from a network of Boron Carbide and Nickel in a hard carbon/iron matrix. Abrasive wear properties are similar to traditional Chromium Carbide alloys of similar hardness. This alloy has excellent weldability with a very smooth bead when used with any common shielding gas. CF-28 is self-fluxing and has no any slag when used without a shielding gas.

## Specifications

### Product Type

Wire: Metal-cored  
Gas shielding, 100% Co2, 75/25 or 98/2  
Also operates Open Arc

### Weld Deposit Properties

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

## Applications

### SURFACING MINING

Shovel Teeth  
Wear Parts  
Dragline Teeth  
Wear Parts  
Bulldozer Blades  
Rippers  
Augers  
PROCESSING  
Mixing and  
Blending  
Screw Conveyors  
Mixer Paddles  
DEEP MINING  
Longwall  
Miners

### Continuous Miners

Cutter Drums  
Conveyor Parts  
DREDGING  
Teeth  
Cutter Drums  
Shovel Teeth  
Wear Parts  
AGRICULTURE  
Subsoiler Teeth  
Tillage tools  
Cultivators  
Sweeps  
Rippers  
Injector knives

### MINERAL PROCESSING

Chutes and Screens  
Screw Conveyors  
Clamshell buckets  
CONSTRUCTION/EARTHMOVING  
Ground Engaging Tools  
Dozer and Grader Blades  
Trencher Teeth  
Ripper Shanks and Teeth  
Shovel Teeth  
Buckets  
Compactors and Tampers  
Foundation Drills  
Asphalt Grinding Drums  
Paving Machine Augers

### TUNNELING

Horizontal Directional  
Drilling Equipment  
Wear Parts  
Augers  
QUARRY EQUIPMENT  
Shovel Teeth  
Shovel Wear Parts/ Adapters and  
Shrouds  
Bulldozer blades and Wear Parts  
Augers  
RECYCLING/DEMOLITION  
Compactor Cleats  
Grapples  
Clamshell Buckets  
Bulldozer Blades  
Wear Parts

## Postalloy® CF-28 Welding Parameters

Current: DC Electrode Positive

Spray Arc	Amps	Volts	Stick Out
1/16" (1.6mm)	20-25	150-250	3/4" (19mm)
.045" (1.1mm)	18-22	100-200	1/2" (12mm)

## Packaging Options

### Diameter Standard Packaging

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

