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Postalloy® Flitewear 2 is a high carbon, chromium rich, molybdenum strengthened hardfacing alloy that produces a dense network of wear resistant chromium carbides in a tough alloy matrix. Recommended for applications subject to abrasion combined with moderate impact. It develops a very tight (3/8-1/2 inch) cross-checking pattern. It can be applied to carbon, low alloy, and manganese steels. Weld deposits can be used in hot wear applications up to 900°F (482°C).

Flitewear Hardfacing wires have been engineered to improve the efficiency and longevity of screw conveyors, augers, rendering screws and other similar components. They are designed with the OEM in mind, where environmental and production issues are unique. They offer excellent welder appeal and out-of-position welding capability. Bead configurations can vary from stringer to wide weave patterns. Welding arcs are smooth and quiet; smoke levels are extremely low; weld deposits are slag free and spatter-free.

## Specifications

### Product Type

Wire: Metal-cored, Open-arc or Gas-shielded  
Deposits are slag-free.

### Weld Deposit Properties

Hardness: 55-60Rc  
Deposit Thickness: 2-3 Layers  
Deposits cannot be flame-cut  
Deposits will check-crack to relieve stresses

## Applications

Foundation drills, Post-hole augers flights, Brick and clay augers, Hollow stem augers and auger flights.

## Postalloy® Flitewear 2 Welding Parameters

Current: DC Electrode Positive or Negative

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	140-200	18-24	3/4"-1"(19-25mm)
1/16" (1.6mm)	170-300	22-28	1"-1¼"(25-32mm)

### Welding Procedure

When welding out of position, use .045 with reverse polarity and the lower range of amperages and voltages. Weld vertical down with 3/4"(18mm) wide weave beads. A gas cover will be helpful, especially when using a constant current power source and voltage sensing feeder.

## Packaging Options

Diameter	Standard Packaging	Available Packaging
.045" (1.1mm)	25 lb spool	220 lb drum
1/16" (1.6mm)	25 lb spool	220 lb drum

