

# Postalloy® INLAY 93 Data Sheet

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Postalloy® Inlay 93 is a gas-shielded iron base high carbon tool steel cored wire that is capable of producing single and multiple layer weld deposits comprised of a large volume of extremely hard multi-Carbides surrounded by a Martensitic matrix. Deposits perform well under low and high stress abrasion and show dramatic improvements over traditional Chromium Carbide products. It was developed to be used in the Weld Inlay process, (Patent Pending) and may be used with carbon, low alloy, AR, T1 and manganese steels. Unlike Chromium Carbide Alloys, Inlay 93 deposits are heat-treatable, allowing for tougher weld metal for applications that encounter moderate impact.

## Specifications

### Product Type

Wire: Inlay: Unlimited thickness with Inlay Plate

### Weld Deposit Properties

Microstructure: Multiple Carbides in Martensitic Matrix

Hardness: 58-61Rc As Welded - Work-Hardens Slightly

Machinability: Poor. Grinding Only.

Deposit Thickness: Unlimited with the Weld Inlay process

Check-Cracking: None with proper procedures

Shielding Gas: Argon 2% Oxygen, Argon 25% CO<sub>2</sub>

Welding Flux: NA

## Applications

Hammers

Klinker rolls

Impact bars

Crusher cones

Chutes and liners

Dozer heel pads

Grouser bars

Crawler pads

Crusher cheek plates

Hammer rotors

## Postalloy® INLAY 93 Welding Parameters

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	100-225	15-26	3/4"-1" (18-25mm)
1/16" (1.6mm)	160-300	20-28	1"-1½" (25-38mm)

Welding Procedure

Contact Postle Technical Staff for WELDING PROCEDURES AND HEAT TREATMENT

## Packaging Options

Diameter	Standard Packaging	Available Packaging
.045" (1.1mm)	25 lb spool	110 lb drum
1/16" (1.6mm)	25 lb spool	55 lb coil, 110 lb drum

