Postalloy® PS-98 Matrix hardfacing wire, alloyed with chromium and molybdenum is developed primarily to be used in conjunction with the MIG Carbide Embedding process. PS-98 Matrix provides a clean, molten and fluid weld bead that readily accepts tungsten carbide grit.

Implements the performance of MIG Tungsten Carbide embedded parts
- Hardness of 55-59Rc protects the tungsten carbide grit which has a hardness in excess of 75Rc.
- The molten weld results in an even distribution of carbide particles throughout the entire weld deposit.

Unlike soft metal steel welding wires which are commonly used with the MIG Carbide Embedding Process, the high hardness tool steel micro-structure of Postalloy® PS-98 Matrix is designed to encapsulate and protect the carbide particles from premature erosion. Use on carbon, low alloy steel and manganese steel.

Specifications

Product Type
Tungsten Carbide Carbide Embedding (Mig Carbide).
Metal cored triple deoxidized iron based wire, alloyed with chromium and molybdenum.
Deposits are slag free.

**RCT™ Reactive Core Technology** improves weldability and optimizes wear properties. Learn more.

Weld Deposit Properties
Hardness (1 Layer): 55-59Rc

Applications
Grader blades
Bulldozer blades
Excavator parts
Dredge cutter teeth
Tunneling equipment
Auger teeth
Wood chippers
Hammers for recycling
Wood-waste
Biomass
Landscaping landfill
Land clearing
Composting
Asphalt shingle recycling
Waste processing systems
Tub grinders

Postalloy® PS-98 Matrix Welding Parameters

Current: DC Electrode Positive

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Amps</th>
<th>Volts</th>
<th>Stick Out</th>
</tr>
</thead>
<tbody>
<tr>
<td>.045” (1.1mm)</td>
<td>170-220</td>
<td>26-28</td>
<td>1&quot;-1½&quot;(25-32mm)</td>
</tr>
<tr>
<td>1/16” (1.6mm)</td>
<td>180-250</td>
<td>27-29</td>
<td>1&quot;-1½&quot;(25-32mm)</td>
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</tbody>
</table>

Welding Procedure
Gas Shielding (98% Argon/2% Oxygen) 35cfh

Packaging Options

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Standard Packaging</th>
<th>Available Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>.045” (1.1mm)</td>
<td>25 lb spool, 50 lb spool</td>
<td>25 lb spool, 50 lb spool</td>
</tr>
<tr>
<td>1/16” (1.6mm)</td>
<td>25 lb spool, 50 lb spool</td>
<td>25 lb spool, 50 lb spool</td>
</tr>
</tbody>
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