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Data Sheet

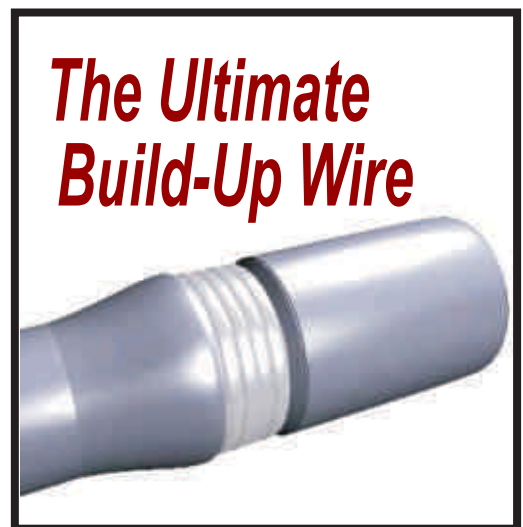
Hardbanding Wire

POSTALLOY[®] HARDBAND BU-MCG

A Premium Build-Up wire for use prior to Hardbanding

Description

Postalloy[®] Hardband BU-MCG is a premium manganese, carbon steel metal cored wire for gas shielded arc welding with a very smooth arc transfer. This wire is intended for multi layer build-up of the critical area directly beneath the hardbanding alloy, where compatibility with higher carbon steel chemistries is critical. Modern manufacturing technology ensures the best consistency, in both weldability and feedability. The cleanliness of **Postalloy[®] Hardband BU-MCG** contributes to low subsurface porosity and the elimination of lack of fusion or "cold laps". Deposits are crack-free, can be readily machined with high speed and carbide tools and can be flame or plasma cut.



Tensile Strength.....91,800 PSI

Welding Parameters

Diameter	1/16" (1.6mm)
Polarity	Electrode Positive
Gas	98% Argon/2% Oxygen (<i>100% Argon, 95/5</i>)
Gas Flow	35 CFH 16.5 LPM (<i>32-37 CFH 15-17.5 LPM</i>)
Current (Amps)	325 (<i>300-365</i>)
Voltage (Volts)	31 (<i>29-33</i>)
Torch Angle	8° (<i>7-10°</i>)
Oscillation Speed	25 Cycles/Minute (<i>22-40</i>)
Maximum Interpass Temperature	850°F (454°C)
Post Welding	Slow Cool to Room Temperature
Stickout	1" (<i>3/4 to 1-1/8"</i>)

Packaging

1/16" dia..... 25 lb. Spools

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