**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 (100% Argon, 95/5)
- **Gas Flow**: 35 CFH 16.5 LPM (32-37 CFH 15-17.5 LPM)
- **Current (Amps)**: 325 (300-365)
- **Voltage (Volts)**: 31 (29-33)
- **Torch Angle**: 8° (7-10°)
- **Oscillation Speed**: 25 Cycles/Minute (22-40)
- **Maximum Interpass Temperature**: 850°F (454°C)
- **Post Welding**: Slow Cool to Room Temperature
- **Stickout**: 1” (3/4 to 1-1/8”)

**Packaging**

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