

Hardfacing Newsletter



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Product Spotlight

Postalloy® 215HD Tubular Electrode

- Superior abrasion resistance
- Better deposition rate, up to 3 times faster
- Lower amperage with less dilution and better first pass hardness
- Storage - moisture resistant coating even under severe weather or high humidity

Postalloy® 215HD is a chromium carbide tubular hardface electrode for hardfacing low carbon mild and alloy steels, manganese steel, stainless steel and cast iron.

Weld deposit chemistries consist of chromium carbides combined in such a way as to produce extremely good abrasion resistance coupled with mild to moderate impact resistance. Hardness 58-62Rc

Tips from the Weld Lab... The importance of good drive roll pressure

Problem: Drive Roll pressure is too high

It's common, when a feeding problem arises, to tighten the drive rolls to grip the wire better to overcome the problem. This is especially true when using knurled rolls for flux cored wire. Because of its construction, flux cored wire is easy to reshape, from round to oval, with drive roll pressure. Instead of having a wire that meets manufacture roundness specifications, an oval or deformed wire can drag in the liner or lock up in the contact tip. Solid wire, when used with knurled drive rolls, won't change shape like flux cored wire, but will develop the teeth and even cause alloy leakage from the wire core that will most likely enter the gun cable liners and cause problems.

Solution: Periodically, before feeding the wire through the cable/hose assembly, use an air nozzle and shop air pressure to blow out the liner, first from the gun end, then, if convenient, from the feeder end. The amount of small debris blown out of the liner will amaze you. Shavings from the wear and wire have a tendency to pack up the liner at noncontact points and junctions (diffuser/tip). This will cause the wire to chatter or stop feeding altogether. It will also wear the liner out more quickly.

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