POSTALLOY® 14

Description

POSTALLOY 14 is a self-fluxing, oxy-acetylene hardfacing alloy that is applied below the fusion temperature of the base metal. It may be used on carbon steels, alloy steels, nickel alloys and cast iron. POSTALLOY 14 flows out easily and may be applied in extremely thin layers. Deposits are non-sparking, non-magnetic, and non-heat treatable.

Excellent cold and hot abrasion resistance - Maintains a high level of hardness up to 1200°F (649°C) .

Outstanding for metal-to-metal wear resistance - Deposits take on an extremely high polish, and will resist galling and freezing when in contact with other metals.

Good Corrosion Resistance - POSTALLOY 14 will provide corrosion protection that is equal to most stainless steels and Inconel alloys.

Applications
Valve seats, Cement and paper pulp mixing blades, Pistons, Forming dies and wire drawing dies, Cams, Overlaying rails, Pump shafts and bushings, Guides and racks in high temperatures, Overlaying edges of augers, Industrial knives, Screws, Cutters and shredders, Impellers

Weld Deposit Properties	
Hardness (*room temp*)	59 Rc
(800°F)	55 Rc
(1000°F)	50 Rc
(1200°F)	45 Rc

POSTALLOY® 21

Description

POSTALLOY 21 is a “self-hardening" wear resistant overlay engineered for abrasion and abrasion combined with medium impact. The alloy chemistry provides good resistance to spalling and chipping while the special low hydrogen coating minimizes dilution and helps to eliminate underbead cracking.

Use on carbon and low alloy steels, It can be used out-of-position and can be used with all types of AC or DC equipment.

Applications
Excavator parts, Bucket lips and teeth, Tamping tools, Dozer and grader blades, Screw conveyors, Grader end bits, Elevator bucket lips, Post hole augers, Muller tires, Wear areas on clamshell, Mining, Dragline and shovel buckets, Earthmoving and construction equipment

Weld Deposit Properties	
Hardness as deposited	56-60 Rc
Deposit Thickness	2-3 Passes
Deposits are non-machinable	

POSTALLOY® 27

Description

POSTALLOY 27 is a build-up electrode in the machinable range of hardness providing wear resistance that is far superior to low and medium carbon steel and low alloy steels. Deposits are extremely tough and have a high resistance to impact and deformation and are not subject to spalling or roll-over. In addition, deposits are dense, crack-free and porosity-free.

Applications
Rebuilding badly worn machine parts back to original dimensions, Roll ends, Shafts, Build-up of parts prior to overlaying with a more wear resistant overlay, Wobblers, Brake drums, Tractor rolls, Sprockets, Rails, Trunnions, Idlers, Dredge pump casings, Gear teeth, Wheels

Weld Deposit Properties	
Hardness	up to 31Rc
Deposit Thickness	as required
Impact Resistance	Excellent
Compressive Strength	High

POSTALLOY® 30

Description

POSTALLOY 30 is a high strength, ductile, crack resistant welding alloy specifically designed for welding problem steels such as, low alloy, high carbon or crack sensitive tool steels. Ideal for welding dissimilar steels - low alloy, spring steels, carbon steels, tool steels.

EXCELLENT JOINING CHARACTERISTICS - With the combination of balanced alloy chemistry and high strength, crack resistant weld deposits, the capability to weld dissimilar problem steels is outstanding.

CARBON HAS NO ADVERSE AFFECTS - Carbon, the cause of most problems associated with weld cracking and hard spots, is rendered harmless.

ACTS AS A SHOCK ABSORBER DURING OPERATION - Since POSTALLOY 30 does not respond to heat-treatment and remains ductile, it has the ability to withstand heavy impact or shock loading

Applications
Shafts and keyways, gear tooth build-up, stamping and forging dies, shovel teeth and blades, wear plates, grousers, heat-treating parts, cracked steel casings, jigs and fixtures and chain links.

Weld Deposit Properties	
Tensile Strength (up to)	120,000psi
Elongation	35%
Machinable with Carbide Tools	
Cannot be flamecut	

POSTALLOY® Super 35

Description

POSTALLOY SUPER 35, a general purpose mild steel electrode, simplifies all welding applications involving mild steel and provides the maintenance welder with a tremendous degree of versatility.

It is remarkably easy to use even on an AC “buzz box”. Just strike the arc and let it go to work. POSTALLOY SUPER 35 is easy to use in all positions and features instant strike and restrike characteristics. The arc is smooth and the slag is self-releasing. High amperage capability for deep penetration when welding through rust, paint, grease and dirt. Deposits on galvanized steels with little or no burning of the Surrounding galvanized coating. Leaves no porosity. Electrode may be bent without the coating popping off when welding hard to reach corners. High degree of moisture resistance.

Applications
Low smoke volume makes it ideal for confined or poorly ventilated areas. Can be used as a contact or “drag” electrode. May be used at the lowest possible amperage to prevent burnthrough on thin sheet metal.

Weld Deposit Properties	
Tensile Strength	80,000psi
Elongation	24%

POSTALLOY® 40

Description

An outstanding aluminum electrode with exceptional weldability and unsurpassed capabilities. The core wire - lowest melting 1000°F (538°C). The coating - extruded... more flux is compacted per inch of core wire than ever before. Together these tow features produce an electrode with superior qualities.

Applications
Foundry defects, Railings, Machining errors, Structural members, Food processing equipment, Welding outdoors when TIG welding become difficult due to erratic shielding gas, Truck and trailer repair, Cracked housings and castings Coverage.

Weld Deposit Properties	
High Tensile Strength	34,000psi
Outstanding Arc Stability	
Highly Concentrated Arc	
Rapid Deposition	

POSTALLOY® 50

Description

For all grades of cast iron and cast iron to steel. POSTALLOY 50 is a unique new electrode that uses "state of the art" coating technology to produce maximum welding performance. It should be used for welding all grades of cast iron and cast iron to steel or stainless.

POSTALLOY 50 offers the following important benefits: Maximum Crack Resistivity due to its ideal combination of strength and ductility, and its high tolerance for harmful contaminants, such as sulfur and phosphorus.

Applications
Dense Deposits on Dirty, Oil-Soaked Cast Iron - The superior arc-purging action of POSTALLOY 50 penetrates through surface contamination as well as contamination that has literally soaked into the casting to produce a solid porosity-free deposit.

Weld Deposit Properties	
Tensile Strength	75,000psi
Hardness	200 BHN
Deposits are machinable	

POSTALLOY® 51

Description

POSTALLOY 51, for welding offers excellent weldability and highly crack resistant deposits . Especially for thin-walled castings and when maximum machinablity is desired after one pass.

Important features of POSTALLOY 51 are: Controlled penetration provides sufficient force to penetrate through surface contaminants, but prevents excessive dilution; Low amperage minimizes the hard brittle zone around the weld; Outstanding machinability; Excellent wash and fluidity; Very good weld beat tie-in; Deposits are dense and porosity -free; POSTALLOY 51 will not turn red and overheat, allowing full use of the electrode.

Applications
Thin wall castings, contaminated steel etc.

Weld Deposit Properties	
Hardness	55,000psi
Tensile Strength	Excellent
Machinability	170 BHN

POSTALLOY® 94

Description

POSTALLOY 94 is a bronze electrode that has the ability to join many types of base metals. Deposits are very tough and wear resistant, developing a tensile strength which will exceed most of the base metals it will be called upon to weld. Typical base metals are: Brass, Bronze, Tool steels, Brass to steel, Bronze to stainless, Cast iron, Copper to steel, Bronze to cast iron, Carbon steel, Copper to stainless, Stainless Steel.
Frictional Wear and Corrosion Resistance - The corrosion resistance is among the best of the copper alloys, providing good resistance to salt water and acids. Deposits work-harden in service and take on an exceptionally high polish.

Applications
Bearings, Valve bodies and seats, Bushings, Guides, Impellers, Gear teeth and pulleys, Mixing arms, Non sparking alloy, Paper mill rolls, Anit-scratch surface, Propellers

Weld Deposit Properties	
Hardness as deposited	150 BHN
Work hardens to	225 BHN
Tensile Strength	100,000psi
Elongation	28%

POSTALLOY® 95 (AC)

Description

Joining and overlaying copper alloys, steel and cast iron. Ideal for dissimilar combinations, such as steel to copper. Excellent weldability. Provides a good combination of strength and ductility. The arc is smooth with a consistent burn-off rate. It may be used out-of-position. The core wire of POSTALLOY 95 and 950 melts well below the melting point of iron base alloys, such as steel and cast iron. This makes it ideal for applications where the use of standard steel or cast iron electrodes would be damaging to the base metal.

Applications
Bearing surfaces, Pumps, Bushings, Valve parts, Impellers, Gear wheels, Bushings, Corroded cast iron parts, Propellers, Galvanized steel

Weld Deposit Properties	
Hardness	100 BHN
Elongation	40%
Tensile Strength	60,000psi
Machinablilty	Excellent

POSTALLOY® 950 (DC Rev)

Description

Joining and overlaying copper alloys, steel and cast iron. Ideal for dissimilar combinations, such as steel to copper. Excellent weldability. Provides a good combination of strength and ductility. The arc is smooth with a consistent burn-off rate. It may be used out-of-position. The core wire of POSTALLOY 95 and 950 melts well below the melting point of iron base alloys, such as steel and cast iron. This makes it ideal for applications where the use of standard steel or cast iron electrodes would be damaging to the base metal.

Applications
Bearing surfaces, Pumps, Bushings, Valve parts, Impellers, Gear wheels, Bushings, Corroded cast iron parts, Propellers, Galvanized steel

Weld Deposit Properties	
Hardness	100 BHN
Elongation	40%
Tensile Strength	60,000psi
Machinablilty	Excellent

POSTALLOY® 205

Description

Ideal for use on manganese steel. Under severe impact, such as hammering or pounding, deposits quickly become tougher and harder, and will not spall or mushroom. POSTALLOY 205 may be used alone, as a combination build-up and hardfacing alloy, or used as a build-up and cushion prior to overlaying with a more abrasion resistant alloy, such as 213 or 214.

POSTALLOY 205 is an all-position electrode for joining or overlaying for high impact. It operates on either AC or DC reverse; the arc is smooth and stable with low spatter loss. Slag removal is easy.

Applications
Coal crushing segments, Shovel drive sprockets, Dipper teeth and lips, Bucket teeth, Pulverizing hammers, Grizzly bars, Shovel tracks, Gear teeth and attaching wear plates, Crusher pads, Railway frogs and switches, Guard rails, Shovel idler wheels

Weld Deposit Properties	
Hardness as deposited	15 - 22 Rc
Work hardens to	55 Rc
Tensile Strength	125,000 psi
Elongation	34%

POSTALLOY® 206HD

Description

POSTALLOY 206HD is a high chromium, nickel, moly alloy electrode that produces deposits with excellent strength and elongation, combined with a high degree of toughness. Weld deposits work-harden in service and provide outstanding impact resistance. The austenitic structure of the weld deposit provides very good corrosion resistance. It's versatility allows it to be used for joining, as well as a cushion layer prior to hardfacing with a harder, more wear resistant alloy.
Use on carbon and alloy steels, stainless and manganese steels and joining dissimilar combinations.

Applications
Rebuilding under carriage components, Impactors, Sprockets, Weld in wear plate, Gear teeth, Cushion layer for hardfacing alloys, Sheaves

Weld Deposit Properties	
Hardness as deposited	100-150 Rb
work hardens to	30-35 Rb
Tensile Strength	100,000psi
Elongation	25%

POSTALLOY® 207

Description

POSTALLOY 207 is a high alloy, work-hardening austenitic manganese steel hardfacing electrode. It can be used equally well for joining and build-up/surfacing of carbon, low alloy and manganese steels. Weld deposits made with POSTALLOY 207 are a modified chromium-manganese chemistry providing an excellent combination of weld metal strength and ductility. Work-hardens rapidly under repeated impact. The yield strength is higher than ordinary manganese alloys providing greater resistance to mushrooming when subjected to compressive loads and repeated impact.

Ideal as a cushioning or buffer layer on manganese steel parts that must be rebuilt on a repetitive basis. Since it will not embrittle until 1000°(538°C), it will act as an insulator to the manganese base metal in helping it keep below 500°(260°C) during the welding operation.

Applications
Fabricating manganese steels, Dragline and power shovel bucket lips and teeth, Manganese to mild or low alloy steels, Railroad crossovers and frogs, Hammer mill hammers, Grizzly bars, Pulverizing hammers, Steel mill wobblers

Weld Deposit Properties	
Hardness as deposited	20 Rc
Work hardens to	50-55 Rc
Tensile Strength	130,000 psi
Elongation	35%

POSTALLOY® 214

Description

POSTALLOY 214 is a high chromium carbide hardfacing electrode for high abrasion and mild impact applications. Deposits take on a high polish, producing excellent frictional and sliding abrasion resistance. Use on carbon and alloy steels, stainless steels and cast iron.

Heat and Corrosion Resistant - Corrosion resistance is equal to straight chromium steels and it retains it's
hardness up to 1000°F(538°C).

POSTALLOY 214 offers good out-of-position welding characteristics on either AC or DC. Fast deposition
rate and easy slag removal. It produces minimum dilution for high first past hardness and deposits are
extremely smooth - almost ripple free.

Applications
Farm implements, Dust fan blades, Asphalt and concrete mixer paddles, Crushing and pulverizing tools, Road ripper teeth, Grader blades, Ditch digger teeth, Muller tires, Conveyor screws, Feed screws, Dredge pump impellers

Weld Deposit Properties	
Hardness (up to)	60 Rc
Deposit Thickness	2-3 passes
Cannot be flame cut	
Relief checks readily to prevent stress build-up.	

POSTALLOY® 215HD

Description

POSTALLOY 215HD hardfacing electrodes, available in 1/4"(6.0mm) and 1/2"(12.5mm), are a unique concept in hardfacing technology. They are tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes.
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. Deposits take on a high polish to resist sliding particle abrasion and will maintain good hot hardness up to 1000°F (538°C).

Due to its unique tubular design, POSTALLOY 215HD offers very smooth operational characteristics. Both the 1/4" and 1/2" diameters will fit standard electrode holders.

Applications

Mining, Quarrying and construction Equipment, Screw conveyors, Dredge bucket lips, Clamshell and dragline buckets, Suction dredge cutter teeth, Bucket lips and teeth, Grizzly bars, Scraper and grader blades, Excellent final layer on manganese jaw crushers and swing hammers, Chutes, liner plates

Weld Deposit Properties

Average Hardness	58-62 Rc
Deposit Thickness	2-3 passes
Cannot be flame cut	
Relief checks readily to prevent stress build-up.	

POSTALLOY® 216HD

Description

POSTALLOY 216HD hardfacing electrodes, available in 1/4"(6.0mm) and 1/2"(12.5mm), are a unique concept in hardfacing technology. They are tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes. Weld chemistry produces a chromium carbide deposit designed for overlaying surfaces exposed to high abrasion and medium impact. Carbides are dispersed throughout a tough alloy matrix that is both heat and impact resistant. Good hot-hardness up to 1000°F (538°C). 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. Deposits take on a high polish to resist sliding particle abrasion and will maintain good hot hardness up to 1000°F (538°C).

Outstanding Features

Excellent AC or DC operation, even on a "buzz box". High metal recovery - no slag to chip. Over 90% efficient. Low amperage - 1/4" from 80 amps, 1/2" from 180 amps.
High deposition rates - up to 3 times faster than ordinary electrode
Moisture resistant coating, even under severe weather or high humidity

Weld Deposit Properties

Average Hardness	58-62 Rc
Deposit Thickness	2-3 passes
Cannot be flame cut	
Relief checks readily to prevent stress build-up.	

POSTALLOY® 218HD

Description

POSTALLOY 218HD is designed for applications involving severe mineral or earth abrasion at temperatures up to 1400°F (760°C). This unique electrode is actually a combination of five types of carbides, uniformly dispersed throughout the weld metal. Several of these carbides have micro-hardness readings that are harder than tungsten carbide. First pass hardness is greater than other wearfacing electrodes - 63 Rc on mild steel. POSTALLOY 218HD hardfacing electrodes, available in 1/4"(6.0mm) diameter, are a unique concept in hardfacing technology. They are tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes. Due to its unique tubular design, POSTALLOY 218HD offers very smooth operational characteristics

Applications

Sinter plant parts, Solid waste shredder parts, Coke pusher shoes, Agricultural implements, Coke crusher segments, Earth moving and construction equipment, Tong bits, Cement mill parts, Slag ladles, Brick making equipment, Ash fans, Cereal grinding equipment and muller plows

Weld Deposit Properties

Average Hardness	63-66 Rc
Deposit Thickness	2 layers
Excellent heat resistance up to 1400°F	
Weld deposits will relief check crack readily	

POSTALLOY® 219HD

Description

When protection with tungsten carbide is needed, POSTALLOY 219HD is an ideal choice. Weld deposits contain tungsten carbide in a chromium rich matrix for added wear and corrosion protection. POSTALLOY 219HD hardfacing electrodes, available in 1/4"(6.0mm) diameter, are a unique concept in hardfacing technology. They are tubular, permitting higher travel speeds and much higher percentages of carbide forming elements contained in the core than with ordinary flux-coated electrodes. Due to its unique tubular design, POSTALLOY 219HD offers very smooth operational characteristics.

Applications
Auger points, Debarking hammers, Cutter teeth, Anvil knives, Flights, Tamping tools, Pilot bits, Sand slinger cups and impeller tips, Mixer paddles and blades, Dragline chains, Screw conveyors, Bucket pin ends, Shredder knives, Ditcher teeth, Muller plows, Dredge bucket lips, Fan blades

Weld Deposit Properties	
Average Hardness	64-68 Rc
Deposit Thickness	2 layers
Cannot be flame cut.	
Relief checks readily to prevent stress build-up.	

POSTALLOY® 250

Description

POSTALLOY 250, for gouging and grooving all metals, removes unwanted metal with standard AC or DC power sources. Unsurpassed For stainless steel or cast iron. Does not require supplementary gas, compressed air or special electrode holders. POSTALLOY 250 produces an intense, highly concentrated blowing action which virtually blasts molten metal and slag out of its path. Leaves a clean, scale-free, carbonfree surface which requires no additional preparation.

The coating constituents in POSTALLOY 250 are formulated to provide a conductive slag during fusion. This imparts self-starting characteristics to the electrode. This feature enables the welder to pre-place the rod in the exact spot where the metal is to be removed without instantaneous arcing.

Applications
Veeing out cracks prior to welding, Gouging out old or defective weld metal, Removing flash and risers, Removing unwanted metal before machining

Weld Deposit Properties

POSTALLOY® 301

Description

POSTALLOY 301 is a high strength, ductile, crack resistant welding alloy specifically designed for welding problem steels such as, low alloy, high carbon or crack sensitive tool steels. Ideal for welding dissimilar steels- low alloy, spring steels, carbon steels, tool steels.

EXCELLENT JOINING CHARACTERISTICS - With the combination of balanced alloy chemistry and high strength, crack resistant weld deposits, the capability to weld dissimilar problem steels is outstanding.

CARBON HAS NO ADVERSE AFFECTS - Carbon, the cause of most problems associated with weld cracking and hard spots, is rendered harmless.

ACTS AS A SHOCK ABSORBER DURING OPERATION - Since POSTALLOY 301 does not respond to heat-treatment and remains ductile, it has the ability to withstand heavy impact or shock loading

Applications
Shafts and keyways, gear tooth build-up, stamping and forging dies, shovel teeth and blades, wear plates, grousers, heat-treating parts, cracked steel casings, jigs and fixtures and chain links.

Weld Deposit Properties	
Tensile Strength (up to)	120,000psi
Elongation	35%
Machinable with Carbide Tools	
Cannot be flamecut	

POSTALLOY® 305

Description

POSTALLOY 305 is designed to weld low alloy, high strength steel such as T-I, Hy-90, Hy-100, SSS-100. An all-position electrode that provides crack-free welds under highly stressed conditions with outstanding elongation and ductility. Easy slag removal.

Applications

Used to fabricate tanks, containers, covers, and high strength pipe. Use for welding low alloy steels containing manganese, nickel, molybdenum, and chromium such as I-beams, angle iron, scaffolding and super structures. Weldments can be used as welded or stress relieved.

Weld Deposit Properties

Tensile Strength (up to)	113,000psi
Elongation	20%
Yield Strength up tp 104,000psi	

POSTALLOY® 344

Description

POSTALLOY 344 is an "all new" high strength mild steel electrode offering very smooth operation coupled with superior out-of-position weldability and penetration. It is ideal for welding thin, medium, heavy and dissimilar gauge steel. Easy "all position" weldability - Never before has an electrode been made that offers both smooth operating features with such as outstanding ability to weld out-of-position. Welding positions such as vertical up and down, flat or horizontal fillets, and overhead can be easily accomplished. Ideal for poor-fit work - With POSTALLOY 344 you won't have to spend time positioning the work to make a perfect joint. With its quick-freezing slag and steady arc, it will easily bridge or fill a gap. Best of all - POSTALLOY 344 won't burn you up. Good penetration does not mean that the sparks have to fly and this is especially true with POSTALLOY 344.

Applications

Ideal for contaminated, dirty steels where surface conditions are poor and surface preparation is impractical. The scavenging action of the coating floats contaminants to the surface creating a solid, porosity-free weld.

Weld Deposit Properties

Tensile Strength	84,000psi
Elongation	24%

POSTALLOY® 505

Description

Cast Iron electrode for welding and joining various types of cast iron and for welding cast iron to steel. Good for heavy sections. Conforms to AWS 5.15.90 Eni Fe-CI.

Applications

Joining various types of cast irons

Weld Deposit Properties

Hardness	200 BHN
Tensile Strength	65,000 psi

POSTALLOY® 515

Description

A high nickel alloy with specially formulated coating produces a smooth arc for low temperature welding of cast iron. It is excellent for “cold welding” in all positions. Weld deposits are highly machinable. Conforms to AWS 5.15.90 ENi-CI.

Applications
Cold welding of cast irons. Highly machinable.

Weld Deposit Properties	
Hardness	170 BHN
Tensile Strength	55,000psi

WeldCor Aluminum

Description

WeldCor Aluminum is an all position 5% silicon aluminum arc welding electrode with exclusive self lifting slag. It is used for low temperature production and maintenance welding of cast and wrought aluminum sheets, plates, castings and extrusions. WeldCor Aluminum provides good color match and excellent corrosion resistance.

Applications
Aluminum Tanks, pipes, appliances, refrigeration equipment, irrigation equipment, automobile parts and parts found in the chemical, food, and laundry industries.

Weld Deposit Properties	
Tensile Strength	34,000 psi
Yield Strength	20,000 psi
Elongation	18%

WeldCor Cast Iron

Description

WeldCor Cast Iron is a machinable cast iron used for welding of cast irons to other cast irons as well as for joining cast irons to mild steels and stainless steels. It is also readily used for the repair of castings.

A preheat and inter-pass temperature of not less than 350°F on cast irons is required during welding to prevent cracking.

Applications
Universal electrode for joining a wide variety of ductile, nodular and malleable cast irons. Ideally suited for the repair of meehanite dies.

Weld Deposit Properties	
Tensile Strength	66,500 psi
Yield Strength	36,000 psi
Elongation	40%

WeldCor Tuffweld 223

Description

A Premium high strength, all position extra low hydrogen moisture resistant steel electrode with exceptional welder appeal. For unalloyed construction steels. Extremely smooth - spatter and turbulence free arc transfer. Coating is totally non-conductive with unusually good AC welding characteristics. Easy re-strike.

Applications

Tuffweld 223 is suitable for joining and repair of a wide range of fine grained medium carbon and low alloy steels such as boiler plate, pipe steels, shipbuilding steels and cast steels. Excellent for weathering steels, such as Corten.

Weld Deposit Properties	
Tensile Strength	84,000 psi
Yield Strength	69,000 psi
Elongation	32%
Impact Energy @ -22F	66 ft/lb

WeldCor Ultimate

Description

For welding all types of steels, without any danger of cracking or breakage. Recommended for repairing worn parts and as an underlay for hardfacing. As welded, WeldCor Ultimate has an "as welded" tensile strength of 128,000 psi but work hardens up to 186,000 psi.

Applications

Ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for aluminum and copper alloys. The special "FERRITE BALANCED" chemistry also serves as a "STUD PULL" electrode.

Weld Deposit Properties	
Tensile Strength as welded	128,000 psi
Yield Strength	90,000 psi
Elongation	36%
Impact Energy @ 68F	37ft/lb