

# POSTALLOY® 2898-SPL

## Data Sheet



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Abrasion resistant. Postalloy®2898-SPL is a general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. POSTALLOY® 2898-SPL is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100°F (593°C). For maximum impact resistance and to avoid cracking in multi-layer deposits, a preheat of 550°F (288°C) is recommended.

## Specifications

### Product Type

Wire: Metal-cored, gas-shielded

Deposits are slag-free.

Gases: Ar/CO, Ar/Ox.

Also available as a flux-cored, open-arc wire - POSTALLOY® 2898-FCO

Electrode equivalent: POSTALLOY® 21

### Weld Deposit Properties

Average Hardness: 55-59Rc

Good Hot-hardness: Up to 1100° F (593°C)

Maximum overlay: Unlimited layers with proper procedures

Non-Machinable: Must be ground

## Applications

Hot Shear Blades

Dozer Blades

Shearing and piercing dies

Tamper feet

Bucket Teeth

Farm Implements Augers

## POSTALLOY® 2898-SPL Welding Parameters

Current: DC Reverse Polarity

Short Arc	Amps	Volts	Stick Out
.035" (0.9mm)	70-190	15-21	1/2"(12mm)
.045" (1.1mm)	90-120	15-21	1/2"(12mm)
1/16" (1.6mm)	150-220	18-21	3/4"(19mm)
Spray Arc	Amps	Volts	Stick Out
.035" (0.9mm)	230-300	20-27	1/2"(12mm)
.045" (1.1mm)	250-325	27-30	5/8"(15mm)
1/16" (1.6mm)	300-375	27-30	3/4"(19mm)

## Packaging Options

### Diameter Standard Packaging

.035" (0.9mm)	25 lb spool
.045" (1.1mm)	25 lb spool
1/16" (1.6mm)	25 lb spool

### Available Packaging

50 lb spool, 110 lb drum, 220 lb drum  
50 lb spool, 55 lb coil, 110 lb drum, 220 lb drum

