

Postle Industries • Cleveland, OH USA • Telephone: 216-265-9000 • Fax: 216-265-9030

TUNGSTEN CARBIDE TUBULAR ELECTRODE

When protection with tungsten carbide is needed, Postalloy® 219HD is an ideal choice. Weld deposits contain tungsten carbide in a chromium cobalt rich matrix, providing a good combination of abrasion resistance with impact toughness. Other features include:

- Excellent AC or DC operation
- Low amperage and high metal recovery - no slag to chip
- High deposition rates - up to 3 times faster than ordinary electrodes
- Moisture resistant coating, even under severe weather or high humidity

Postalloy® 219HD hardfacing is a unique concept in hard facing technology and is over 90% efficient. It's tubular design offers very smooth operational characteristics and permits higher travel speeds and much higher percentages of carbide forming elements contained in the core as compared to ordinary flux-coated electrodes.

Specifications

Product Type

Flux-coated Tubular Electrode alloyed with Tungsten Carbide and Chromium

Weld Deposit Properties

Hardness: 64-68Rc

Deposit thickness: 2 layers

Relief checks readily to prevent stress build-up.

Cannot be flame-cut.

Applications

Auger points

Debarking hammers

Cutter and dredge teeth

Tamping tools

Bucket pin ends

Shredder and anvil knives

Muller plows

Mixer paddles and fan blades

Dredge teeth

Postalloy® 219HD Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
1/4" (6.0mm)	80-130
3/8" (9mm)	130-180
1/2" (12mm)	180-220

Welding Procedure

Remove old hardfacing and any fatigued base metal. Postalloy® 250 gouging electrode is useful for this purpose. Preheat from 200-400°F (93-204°C) is recommended for steels with a carbon content of .25 to .45. Steels with a higher carbon level should be preheated from 400-700°F (204-371°C). Do not preheat austenitic manganese steel. Use a minimum arc length equal to about the diameter of the electrode. Hold the electrode at 90° to the work surface for proper application. Do not apply more than two layers. On manganese or hardened steel, an intermediate or cushion layer of Postalloy® 207 is recommended.

Packaging Options

Diameter	Standard Packaging
1/4" (6.0mm)	Resealable Plastic Box
3/8" (9mm)	Resealable Plastic Box
1/2" (12mm)	Resealable Plastic Box



Auger point