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Postalloy® 210HD is formulated with a high percentage of Chromium Carbide producing a tubular hardfacing electrode that is highly resistant to abrasion with mild or moderate impact. Weld deposits are smooth and take on a high polish to resist sliding particle abrasion. It can be applied to carbon and alloy steels, as well as a cast iron.

High Compressive Strength - Deposits do not tend to shatter and spall off under conditions of high impact. Ideal for gouging abrasion.

Hardness at Elevated Temperatures - The hardness and wear resistance of Postalloy 210HD is maintained up to 1000°F(538°C).

Welding characteristics are outstanding - Postalloy® 210HD can be used on any type of welding machine, either AC or DC, in both flat and vertical positions.



Grapple Hook

Specifications

Product Type

Flux-coated Tubular Electrode

Weld Deposit Properties

Hardness as Deposited: 50-55Rc

Deposit Thickness: up to 3 layers

Relief checks readily to prevent stress-buildup.

Cannot be flame-cut.

Applications

Swing hammers

Fixed hammers

Shovel buckets

Crusher rolls (rock & shale)

Muller tires

Bucket lips and teeth

Blow bars

Tampers

Mill hammers

Log grapples

Postalloy® 210HD Welding Parameters

Current: AC or DC Straight or Reverse

Diameter	Amps
1/4" (6.0mm)	80-130
3/8" (9mm)	140-190
1/2" (12mm)	190-260

Welding Procedure

Due to lower dilution, DC polarity will produce a higher first pass hardness and is also ideal for thin sections. Remove all damaged or fatigued metal. Preheating is generally not required. However, for high carbon or alloy steels and cast iron, a preheat of approximately 400°F (204°C) is required.

Packaging Options

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

