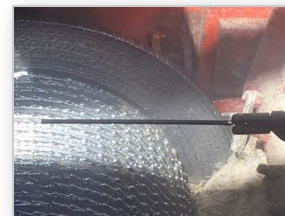


Postalloy® 216HD Data Sheet

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Postalloy® 216HD (Chapisco), for Roll-Arcing, is primarily engineered for the sugar cane industry and is to be used while the sugar cane roll is rotating. Postalloy® 216HD produces a rough weld deposit that will aid in pulling, tearing and crushing the sugar cane as it feeds through the rolls during processing. Also used for sugar mill rolls hooks (Picote).



Sugar Mill Roll

Postalloy® 216HD is a chromium carbide tubular hardfacing electrode with much higher percentages of carbide forming elements contained in the core than with conventional flux-coated electrodes. It's tubular construction allows it to be used at higher deposition rates and much lower current settings than traditional flux-coated electrodes. 1/4" (6.0mm) is used around 100 amps. Weld chemistry produces a chromium carbide weld deposit for overlaying surfaces exposed to high abrasion and medium impact.

Specifications

Product Type

Flux-coated Tubular Electrode

Weld Deposit Properties

Hardness: 58-62Rc

Deposit Thickness: 2-3 passes

Relief checks readily to prevent stress build-up.

Cannot be flame-cut.

Applications

Sugar mill rolls (Chapisco)

Sugar mill roll hooks (Picote)

Cane rakes & combs

Casing cane crushers

Hammers & bits

Fan (ID) boiler

Fibrizor hammers (Martillo)

Cane knives (Cuchillas)

Outstanding Features

- Can be applied while the rolls are operating
- Excellent AC or DC operation
- 90% efficient
- Moisture resistant coating, even under severe weather or high humidity
- All diameters 1/4" (6.0mm), 3/8" (9.5mm), and 1/2" (12.7mm) will fit standard electrode holders
- High metal recovery - NO SLAG
- Low amperage
- High deposition rates, up to 3 times faster than ordinary electrodes

Postalloy® 216HD Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
1/4" (6.0mm)	81-120
3/8" (9mm)	150-180
1/2" (12mm)	180-325

Welding Procedure

Packaging Options

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

