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Postalloy® 217HD is modified Chromium Carbide tubular hardfacing electrode, alloyed with Niobium and a small addition of Molybdenum. The microstructure has very fine carbides which give improved wear, erosion and impact resistance over traditional Chromium Carbides. It is designed for applications that require more abrasion resistance than Postalloy® 215HD. The Carbide concentration is denser and slightly harder but less brittle than Postalloy® 215HD providing a better, more wear-resistant surface.

- Excellent DC operation.
- High metal recovery - no slag to chip. Postalloy® 217HD is over 90% efficient.
- Low amperage
- High deposition rates - up to 3 times faster than ordinary electrode
- Moisture resistant

## Specifications

### Product Type

Flux-coated Tubular Electrode

### Weld Deposit Properties

Average Hardness: 50-60Rc

Maximum Deposit Thickness: 2 layers

Weld deposits will relief check-crack readily

Heat Resistant to: Excellent up to 1100°F (593°C)

## Applications

Mining and quarry equipment  
Dredge bucket lips and teeth  
Scraper and grader blades  
Crusher mantles and liners  
Screw conveyors

Construction equipment  
Excellent final layer on manganese jaw crushers and swing hammers  
The 1/4" size is ideal for vertical, edge and stringer beads  
The 3/8" size is ideal for covering large areas and button hardfacing

## Postalloy® 217HD Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
1/4" (6.0mm)	80-120
3/8" (9mm)	140-190
1/2" (12mm)	180-220

### Welding Procedure

Remove old hardfacing and any fatigued metal if weld spalling or cracking is a problem. Many steels can be hardfaced without special preheats, if the welding alloy used has relief checking. A low preheat of 150°F (66°C) may sometimes aid in weldability. Do not preheat austenitic manganese steels. The interpass temperature of austenitic manganese and most steels should be less than 500°F (260°C). Electrode angles should be slightly less than 90°. Do not apply more than two layers. A short arc length and stringer beads are recommended to reduce weld dilution.

## Packaging Options

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

