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

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Amps</th>
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<tbody>
<tr>
<td>1/4” (6.0mm)</td>
<td>80-130</td>
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<tr>
<td>3/8” (9mm)</td>
<td>130-180</td>
</tr>
<tr>
<td>1/2” (12mm)</td>
<td>180-220</td>
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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

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Standard Packaging</th>
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<tbody>
<tr>
<td>1/4” (6.0mm)</td>
<td>Resealable Plastic Box</td>
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