

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

Postalloy® TungGuard™ 299-MCO is an open-arc hardfacing overlay that utilizes a specially formulated tungsten carbide to produce a "highly feathered" microstructure that is unusually hard and more abrasion resistant than standard tungsten carbide hardfacing wires. Operates at lower than normal currents to minimize dilution and help develop its high hardness and unique microstructure in the first layer. For extreme earth abrasion resistance with little or no impact.

Specifications

Product Type

Tungsten Carbide Wire: Metal-cored, open-arc
Deposits are slag-free

Weld Deposit Properties

Hardness: Tungsten Carbide - 2300 HV
Average hardness of weld deposit matrix alloy: 60-65Rc
Deposit Thickness: 2 layers maximum
Deposits will readily relieve check-crack

Applications

Scraper blades
Bulldozer blades/end bits
Grader blades/bits
Stabilizers

Mixer screws
Feed screws
Fan blades
Concrete mixer paddles

Postalloy® TungGuard™ 299-MCO Welding Parameters

Current: DC Electrode Positive

Diameter	Amps	Volts	Stick Out
1/16" (1.6mm)	120-240	23-26	1"-1½" (25-38mm)
3/32" (2.4mm)	250-350	23-26	1½" (38mm)

Packaging Options

Diameter	Standard Packaging
1/16" (1.6mm)	25 lb spool
3/32" (2.4mm)	55 lb coil

