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Postalloy® 30 is a high strength, ductile, crack resistant welding alloy specifically designed for welding problem steels such as, low alloy, high carbon or crack sensitive tool steels. Ideal for welding dissimilar steels- low alloy, spring steels, carbon steels, tool steels. The benefits of Postalloy® 30 include:

- Excellent joining characteristics - With the combination of balanced alloy chemistry and high strength, crack resistant weld deposits, the capability to weld dissimilar problem steels is outstanding.
- Carbon has no adverse effects - Carbon, the cause of most problems associated with weld cracking and hard spots, is rendered harmless.
- Acts as a shock absorber during operation - Since Postalloy® 30 does not respond to heat-treatment and remains ductile, it has the ability to withstand heavy impact or shock loading.

Specifications

Product Type

Flux-coated electrode

Also available as semi-automatic welding wire 301-SPL and 301-FCG.

Weld Deposit Properties

Tensile Strength: Up to 120,000 psi

Elongation: 35%

Machinable with Carbide Tools

Deposits cannot be flame-cut

Applications

Shafts and keyways

Gear tooth buildup

Stamping and forging dies

Shovel teeth and blades

Wear Plates

Grouzers

Heat-treating parts

Cracked steel casings

Jigs and fixtures

Chain links

Postalloy® 30 Welding Parameters

Current: AC or DC Reverse Polarity

Diameter	Amps
3/32" (2.4mm)	50-80
1/8" (3.1mm)	80-125
5/32" (4.0mm)	100-150

Welding Procedure

Clean weld area of contaminants. Remove any defective or fatigued weld metal. Bevel heavy sections 90°. Tilt the electrode about 15° in the direction of travel and use the lowest amperage possible. For certain high alloy steels, a preheat of 300-400°F(149-204°C) is recommended. Hold a short arc and use stringer beads. Peen to reduce stresses. Allow to cool and remove slag.

Packaging Options

Diameter	Standard Packaging
3/32" (2.4mm)	Resealable Plastic Box
1/8" (3.1mm)	Resealable Plastic Box
5/32" (4.0mm)	Resealable Plastic Box

