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Postalloy® 301-FCG is a high strength, crack resistant flux-cored, gas-shielded all-position 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® 301-FCG 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® 301-FCG does not respond to heat-treatment and remains ductile, it has the ability to withstand heavy impact or shock loading.

Specifications

Product Type

Wire: Flux-cored, Gas-shielded
Electrode equivalent: Postalloy® 30

Weld Deposit Properties

Tensile Strength: 120,000 psi
Elongation: 35%
Machinable with Carbide Tools
Deposits cannot be flame-cut

Applications

Shafts and keyways	Grouzers
Gear tooth buildup	Heat-treating parts
Stamping and forging dies	Cracked steel casings
Shovel teeth and blades	Jigs and fixtures
Wear plates	Chain links

Postalloy® 301-FCG Welding Parameters

Current: DC Electrode Positive

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	Flat: 180- 200	Flat: 25 - 27	Flat: 5/8"-3/4"(15-19mm)
	Vertical: 150-170	Vertical: 24-26	Vertical: 5/8"-3/4"(15-19mm)
	Overhead: 175-195	Overhead: 25-27	Overhead: 5/8"-3/4"(15-19mm)

Welding Procedure

Gas Coverage - Argon/CO₂(75/25) at a flow rate of 40 cfh

