

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

Postalloy® 301-SPL 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® 301-SPL include the following:

- 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-SPL does not respond to heat-treatment and remains ductile, it has the ability to withstand heavy impact or shock loading.

## Specifications

### Product Type

Wire: Solid wire, 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	Grousers
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-SPL Welding Parameters

Current: DC Electrode positive

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	75-300	16-27	1/2"-5/8" (12-15mm)

### Welding Procedure

Postalloy® 301-SPL can be used in short-arc with Argon/CO(75/25) or in spray-transfer with 2 Argon/Oxygen(98/2). Recommended gas flow is 40-50 cfh. Use short-arc welding for thinner materials, root passes and welding out-of-position. Use spray transfer for welding in the flat position.

