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Non-Mag Hardbanding Wire

Data Sheet

POSTALLOY® 2814HB®

Description

Postalloy® 2814HB® is a gas shielded, metal cored, high hardness, Nickel base hardbanding wire designed specifically for use on MWD/LWD non-magnetic drilling tools. It can be applied in multiple layers without spalling providing standard preheat and interpass temperatures are used. It can be applied successfully to Monel, Cr-Mn, and Nitronic non-magnetic stainless tools. Standard Mig equipment is required and operated at typical parameters:

Amps: 275

Volts: 28 Electrode Positive

Gas: 98% Argon/2% Oxygen (or other Ar/O mixtures)

Torch Lead: 1" (25mm)

Torch Angle: 10° to 15°

Flow: 35CFH

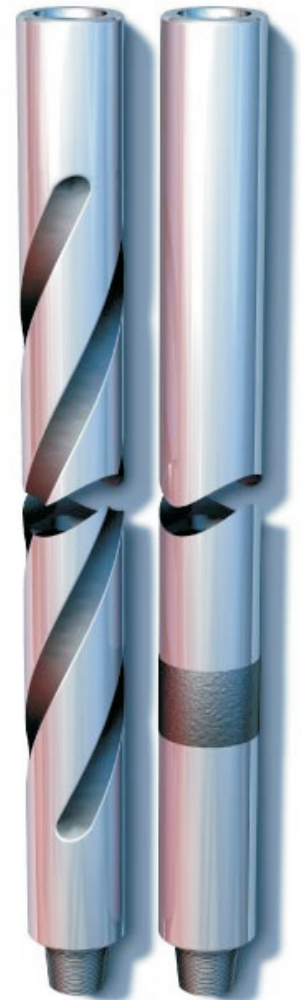
Electrical Stickout: 3/4" to 1-1/4" (19mm to 32mm)

Weave: 3/4" to 1" (19mm to 25mm)

Preheat: 250°F to 300°F (120°C to 150°C)

*Interpass: ~ 350°F (177°C) **Do Not Exceed 500°F (260°C)***

2814HB® Deposits are smooth, ripple free, and slag free. Excellent wear resistance is provided by a tough Nickel matrix with numerous amounts of hard constituents, producing a hardness from 55Rc to 60Rc. Re-application is easy providing the worn deposit is clean and free of defects.



Packaging

Diameter	1/16" (1.6mm)
30 Lb. Spools	Standard

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