

# POSTLE INDUSTRIES, INC.



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Data Sheet

## POSTALLOY® HB-BU

A Premium Build-Up wire for  
use prior to Hardbanding

The Ultimate  
Build-Up Wire



### Description

Postalloy HB-BU is a premium medium manganese, carbon steel metal cored wire for gas shielded arc welding with a very smooth arc transfer. This wire is intended for multi-layer build-up of oil drilling tool joints, where compatibility with higher carbon steel chemistries is critical. Modern manufacturing technology ensures the best consistency, in both weldability and feedability. The cleanliness of **Postalloy HB-BU** contributes to low subsurface porosity, and the elimination of lack of fusion or “cold laps”. Deposits are crack-free, can be readily machined with high speed and carbide tools, and can be flame cut or plasma cut.

### Welding Parameters

Size (in)	1/16
Amperage	240-500
Voltage	28-34
Wire Speed, I.P.M	175-500
Recommended Stick-out	3/4 to 1.25”

### Packaging

1/16” dia..... 25 lb. Spools