

POSTLE INDUSTRIES, INC.

P.O. Box 42037 • Cleveland, Ohio 44142
Fax: 216-265-9030 • Phone: 216-265-9000 • Toll Free: 800-321-2978
E-Mail: sparky@postle.com • Web Site: www.hardbandingsolutions.com



Data Sheet

POSTALLOY® Tool Joint BU SA

A Premium Submerged Arc
Build-Up wire for use prior to
Hardbanding

The Ultimate
Build-Up Wire



Description

Postalloy Tool Joint BU SA is a premium medium manganese, carbon steel metal cored wire for submerged 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 Tool Joint BU SA** 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

Diameter	1/8” (3.2mm)
Current	350-400
Voltage	30-32
Wire Extension	1-1.5” (25-38mm)
Flux Type	Lincoln 860, 802, 804
Position	Flat
Hardness on 4137 Steel	30-35Rc

0410SS