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POSTALLOY® TUBE BANDINGSM

DURABAND[®] NC APPLICATION ON WORK STRING COMPLETION TUBING

Duraband[®] NC can be applied to Work String Completion Tubing to increase service life. A maximum of one band can be applied to both pin and box near the taper allowing for multiple re-cuts as necessary.



Application Procedures

1. Application surface must be free from rust, scale, grease, dirt or other materials. Clean surface by sandblasting, grinding or with flap disk.
2. Switch polarity on welder. **ELECTRODE NEGATIVE (DC STRAIGHT POLARITY) IS REQUIRED!**
3. Pre-heat upset to 225°F (107°C) You MUST pre-heat for successful application!
4. Apply **Duraband*** at a thickness of 3/32 (+1/32 / -0) as per parameters listed.
5. Apply one 1" band maximum – locate band 3/8" minimum from taper
Note: A minimum pin length of 1.875" and box length of 4.875 are required for re-application
DO NOT HARDBAND OVER THREADED AREA OF A BOX CONNECTION!
6. Any grinding of hardbands may be done after the work has cooled to 150°F (65°C) or less.
7. Use a Postle HB Insulator, cooling can or insulation to slow cool.

**This process can only be used with Duraband.
Do not use Tuffband!*

Typical Welding Parameters

Diameter: 1/16" (1.6mm)

Polarity: **ELECTRODE NEGATIVE** (see diagram)

Gas: 98% Argon/2% Oxygen

Gas Flow: 32-37 CFH (15-17.5 LPM)

Amperage: 320 (300-320)

Volts: 29 (27-30)

Stickout: 7/8" (21mm) (5/8"-1" 16-25mm)

Oscillation Width: 1" (25mm)

Oscillation Speed: 90 per minute (80-100 per minute)

Preheat: 225°F (107°C)

Max Interpass: 700°F (370°C)

Rotational Speed:

2 3/8 Tubing (2.8-2.9 OD Connection) - 70 Seconds

2 7/8 Tubing (3.2-3.4 OD Connection) - 80 Seconds

