Application Guide

POLARITY: Electrode Positive - DCEP/Reverse

AMPERAGE: Tuffband 330 (300 to 380)
            Duraband 320 (300 to 365)

VOLTS: 30 (28 to 33)

GAS MIX: 98% Argon/2% Oxygen (100% Argon, 95/5)

GAS FLOW RATE: 35 CFH (16.5 LPM)
                  (32 to 37 15-17.5 LPM)

TORCH
ANGLE: 15° (10° to 17°)
OFFSET: 1” (25mm) (3/4 to 1-1/2” 19-38mm)
STICKOUT: 1” (25mm) (3/4 to 1-1/8” 19-28.5mm)

OSCILLATION
WIDTH: 1” (25mm) (3/4 to 1-1/4” 19-32mm)
SPEED: 80 per minute (60 to 100)
TIE-IN: Use 10-15% Band Overlap

PREHEAT: See Chart on Reverse Side

MAX INTERPASS TEMPERATURE: 850°F (454°C)

SLOW COOLING: Cover immediately with Postle HB Insulator or cooling can

RECOMMENDED ROTATIONAL SPEED:
7 seconds per inch of circumference
Connection OD x 3.14 = Circumference
Circumference x 7 seconds = Rotation Speed (seconds)

Adjust Parameters as Needed to Achieve Best Bead Profile
Black - Recommended  Red - Parameters

WIRE USAGE CHART
(Lbs of Hardbanding to Order)

Preheating is even more critical when applications are being done on BHA components due to the material thickness which is typically 1” (25mm) on HWDP and up to 2” (50mm) on collars. Thicker materials require much more time and attention when preheating.

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