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HARDBANDING SOLUTIONS by POSTLE INDUSTRIES

Data Sheet

Hardbanding Wire

POSTALLOY® DURABAND® NC

Description

Postalloy® DURABAND® NC is a 100% crack-free hardband that provides maximum protection of the tool joint and casing.

DURABAND® NC microstructure consists of a hard, but tough tool steel matrix with a high volume of tightly packed micro-constituents. This combination ensures excellent wear resistance in open hole drilling as well as being *CASING FRIENDLY*. Typical hardness values of 57-60Rc can be expected when applied to new tools or properly rebuilt joints. Deposits are smooth and free of any slag. DURABAND® NC can be applied over itself and over TUFFBAND® NC without removal, but only if the surface has been properly cleaned and inspected. DURABAND® NC can be applied over some competitive products without removal. Please contact our Engineering Department for complete procedures.

NS-1 LEVEL 2

Duraband® NC Hardbanding Uses: New Application and Re-Application to Tool Joints

Welding Parameters

Diameter	1/16” (1.6mm)
Polarity	Electrode Positive
Gas	98% Argon/2% Oxygen
Gas Flow	32 - 37 CFH *(Typical 35 CFH)*
Current *amps*	300-365 *(Typical 320A)*
Voltage *volts*	29-33 *(Typical 30V)*
Stickout *inch (mm)*	3/4”-1-1/4” (19-32mm)*(Typical 1” or 25mm)*
Preheat	350/450ºF (165/232ºC)
Maximum Interpass	800 ºF (427ºC)
Post Welding	Slow Cool to Room Temp

Packaging 50 Lb. Spools Standard

Other packaging available upon request

Power sources often operate differently even with the same consumable weld wire. If switching from a rectifier (inverter), which is often found in stationary units, to a motor generator, which is often found on mobile units, a slight adjustment in welding parameters may be necessary. This is also true when switching from a motor generator to a rectifier (inverter). Usually a slight change in wire feed (amperage), voltage and electrical stickout will be enough to arrive at acceptable settings.