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Data Sheet

Hardbanding Wire

POSTALLOY® TubeWeld 110

U.S. Pat. No. US 10,751, 824 B2

A Premium Build-Up Wire for the Rebuilding of Work String Tubing Upset Connections

Description

Designed specifically for the rebuilding of Work String Upset Connections, Postalloy® Tube-Weld 110, provides specific metallurgical properties and weldability under unique conditions. This combination of carefully controlled heat and very tight welding parameters, using a specified patent-pending welding procedure, significantly reduces the possibility of burning through the original metal.

Once the weld has been properly applied, the weld material is milled to the connection's originally specified diameter and the threads are re-cut.



TubeWeld 110 as Welded

Welding Parameters

Process: Gas Shielding GMA

Shielding Gas: 75% Argon/25% Co2 Only*

(DO NOT USE 98% Argon/2% O2)

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

Wire Size: .045" (1.14mm) Tube-Weld 110

Preheat: 80-100°F (27-38°C)

Polarity: DC STRAIGHT* (Electrode Negative)

Amperage: 165 (165-190)

Volts: 21.5 (21-22)

Oscillation Width: 3/8" (9.5mm)

AUTO STEP-OVER MUST BE USED*

Oscillation Speed: 80-100 per Minute

Overlap: Minimum 1/8" (3.2mm)

Rotation Speed: 2.906" (74mm) 42 Sec/Revolution

3.438" (87mm) 50 Sec/Revolution

Torch Angle: 12° (10°-14°)

Offset: 3/4" (19mm) 3/4 to 1 (19-25mm)

Stickout: 1/2" (12.5mm)

Max Interpass Temperature: 800°F (427°C)

Post Weld: Slow Cool to Room Temperature



TubeWeld 110 Machined and Connections Recut

*** 75% ARGON/25% Co2 GAS, STRAIGHT POLARITY AND AUTO STEP-OVER MUST BE USED FOR PROPER APPLICATION NO EXCEPTIONS!**

