

## Postle Industries, Inc.

Cleveland, OH USA

Phone: 216-265-9000

Fax: 216-265-9030

E-Mail: [sparky@postle.com](mailto:sparky@postle.com)

Web Site: [www.hardbandingsolutions.com](http://www.hardbandingsolutions.com)



# Hardbanding Wire

Data Sheet

## POSTALLOY<sup>®</sup> HB-50

### Description

HB-50<sup>®</sup> is the perfect product when initial cost-saving is the priority, but the reliability of Postle defect-free application and reapplication are retained. Its stable chemistry make it a safe option in comparison to similarly priced wires.

HB-50 microstructure consists of a tough tool steel matrix with hard micro-constituents for added wear resistance. This combination ensures very good wear resistance in open hold drilling as well as being CASING FRIENDLY. Typical hardness values of 54-57Rc can be expected when applied to new tools or properly rebuilt joints. Deposits are smooth and free of any slag.

HB-50 can be applied over some competitive products without removal. Please contact our Engineering Department for complete procedures.



### Welding Parameters

Diameter	1/16" (1.6mm)
Polarity	Electrode Positive
Gas	98% Argon/2% Oxygen ( <i>100% Argon, 95% Argon/5% CO2</i> )
Gas Flow	35 CFH 16.5 LPM ( <i>32-37 CFH 15-17.5 LPM</i> )
Current <i>amps</i>	330 ( <i>300-365</i> )
Voltage <i>volts</i>	30 ( <i>29-33</i> )
Stickout	1" (25mm) ( <i>3/4 to 1-1/8" 19-28.5mm</i> )
Preheat	350/450°F (165/232°C)
Maximum Interpass	850 °F (454°C)
Post Welding	Slow Cool to Room Temp

**Packaging** 50 Lb. Spools Standard

Other packaging available upon request

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