

Crack-Free Duraband®NC and Tuffband®NC

Duraband and Tuffband chemistries have not changed since they were introduced over ten years ago. They are still both 100% Re-Buildable, Casing Friendly and 100% Crack-Free. In addition to these advantages, they can both be re-applied over many competitive products without removal of the previous hardbanding. Several of these re-application processes are supported with documentation from both Fearnley Procter and TH Hill.

• When to Accept only 100% Crack Free Applications •

Please note that Duraband & Tuffband are guaranteed to be crack-free on **new applications** and **re-applications over themselves or each other**, regardless of the remaining thickness of the previous hardbands.

• When to Expect Reduced Cracking •

The same is not true with first re-applications over some cracking competitive products. Re-applications are only as good as the previously applied hardbanding. Per our manuals, when re-applying over a cracking hardbanding or hardbanding that has previous, acceptable amounts of porosity, you can expect some of the cracking and porosity, though greatly reduced amounts, to show up in the finished Duraband & Tuffband hardbanding. Subsequent re-applications will be crack-free.

The most important thing to remember is that we have an experienced support team to help you immediately whether in person, via phone, FaceTime or WhatsApp. The time to contact us is when you start to have issues that you cannot resolve with some minor adjustments, not 25 or 50 joints into the job. See attached Applicator Map or Website for Tech Center contacts. Do not hesitate to call us with questions and concerns as often as needed. We want to help you be successful with our products!

Let's review the process for re-application over a competitive product:

1. Determine if it's a candidate for re-application. The condition of existing hardbanding is crucial. There cannot be any spalling or severe cracking. If so, remove all of the old hardbanding.
2. Existing hardband thickness should be $\leq 1/32"$.
3. Determine what hardbanding is on the pipe. If it's not one of the products listed in our manuals, contact Postle or your Tech Center for re-application approval.
4. Keep in mind that you will need to make minor adjustments that may change joint to joint. Re-application is not a "set it and forget it" procedure. It requires constant attention every time.
5. Apply Duraband or Tuffband as instructed in our manuals. If you are having any issues that cannot be fixed with minor adjustments...**STOP**. Again, contact Postle or your Tech Center before proceeding.
6. If Duraband is the preferred hardbanding and you are having issues with a particular joint(s), chances are there's a "mixed batch" of hardbanding from previous applications on the pipe. In those cases where you only have a few joints and Duraband is giving you problems, we recommend using Tuffband the first time and when it comes back in, re-apply Duraband. Tuffband should only be used (unless specified by your customer) as a fix. If you are experiencing consistent issues with Duraband on a particular job, contact us before proceeding!
7. Once hardbanding is completed and tool joints are slow cooled properly, check for issues. Fine longitudinal and bi-directional cracks are no issue. If you have some transverse cracks, lightly grind or remove with flap disc. If a transverse crack is deeper than $1/32"$, remove the hardbands and start over.

Hardbanding Tip

When switching gas cylinders, be sure to open the valve on the tank for 2 or 3 seconds prior to attaching your regulator. This will allow for any dirt or sealant to clear and prevent contamination from clogging your regulators.