

Postle Industries, Inc.

Cleveland, OH USA

Phone: 216-265-9000

Fax: 216-265-9030

E-Mail: sparky@postle.com

Web Site: www.hardbandingsolutions.com



POSTALLOY® DURABAND® NC APPLICATION ON WORKSTRING COMPLETION TUBING

Duraband® NC can be applied to Workstring Completion Tubing to increase service life. A maximum of one band can be applied to both pin and box near the taper allowing for multiple re-cuts as necessary.



Application Procedures

1. Application surface must be free from rust, scale, grease, dirt or other materials. Clean surface by sandblasting, grinding, wire brushing or with wire wheel.
2. Switch polarity on welder. **DC STRAIGHT POLARITY IS REQUIRED!**
3. Pre-heat upset to 225°F (107°C).
4. Apply **Duraband*** at a thickness of 3/32 (+1/32 / -0) as per parameters listed.
5. Apply one 1" band maximum – locate band 3/8" minimum from taper
Note: A minimum pin OD length of 1.875" and box OD length of 4.875 are required for re-application
6. Any grinding of hardbands may be done after the work has cooled to 150°F (65°C) or less.
7. Use insulating bags, cooling cans or insulation to slow cool.

**This process can only be used with Duraband*

Typical Welding Parameters

Diameter	1/16" (1.6mm)
Polarity	DC STRAIGHT POLARITY <i>(see diagram)</i>
Gas	98% Argon/2% Oxygen
Gas Flow	32-37 CFH <i>(Typical 35 CFH)</i>
Current amps	270-290 <i>(Typical 280A)</i>
Voltage volts	27-30 <i>(Typical 29V)</i>
Stickout	3/4"-1" (18-25mm) <i>(Typical 7/8" 21mm)</i>
Preheat	225°F (107°C)
Max Interpass	700°F (370°C)
Rotational Speed	2 3/8 Tubing (2.8-2.9 OD Connection) - 50 Seconds 2 7/8 Tubing (3.2-3.4 OD Connection) - 60 Seconds
Post Weld	Slow Cool to Room Temperature

