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Data Sheet

Hardbanding Wire

POSTALLOY® OPEN-HOLE HB

Postalloy® OPEN-HOLE HB is a tubular hardbanding wire that provides a dense heterogeneous deposit of a complex alloy of vanadium carbides, along with other elements, to enhance abrasion and impact wear resistance. The hardband deposit is much smoother than dropped-carbide.

Recommended where drilling is mostly in open hole with minimal side-load pressures.

The unique composition of **Postalloy® OPEN-HOLE HB** is ideally balanced to provide a uniform distribution of complex vanadium carbide alloy throughout the deposit. The uniform distribution of the carbides offers enhanced abrasion resistance and longer wear life than Duraband®NC. It can be applied over Duraband®NC or Tuffband®NC and it is also very receptive to multiple re-applications.

Postalloy® OPEN HOLE HB deposits are slag free

Applications: Recommended where drilling is mostly in open hole with minimal side-load pressures

Welding Parameters

Diameter	1/16" (1.6mm)
Polarity	DC Straight or Reverse Polarity
Gas	98% Argon/2% Oxygen (Can be ran Open-Arc or Gas-Shielded)
Gas Flow	32 - 37 CFH (<i>Typical 35 CFH</i>)
Current <i>amps</i>	150-260 (<i>Typical 190A</i>)
Voltage <i>volts</i>	22-32 (<i>Typical 26V</i>)
Stickout	1/2" - 3/4" (13-19 mm) (<i>Typical 5/8" or 16mm</i>)
Preheat	350°F to 650°F (177°C to 343°C)
Maximum Interpass	850°F (454°C)
Post Welding	Slow Cool to Room Temperature

Packaging 25 Lb. Spools