

Postle Industries, Inc.

Cleveland, OH USA

Phone: 216-265-9000

Fax: 216-265-9030

E-Mail: sparky@postle.com

Web Site: www.hardbandingsolutions.com



Data Sheet

Hardbanding Wire

POSTALLOY® HARDBAND BU-MCG

A Premium Build-Up wire for use prior to Hardbanding

Description

Postalloy® Hardband BU-MCG is a premium manganese, carbon steel metal cored wire for gas shielded arc welding with a very smooth arc transfer. This wire is intended for multi layer build-up of the critical area directly beneath the hardbanding alloy, where compatibility with higher carbon steel chemistries is critical. Modern manufacturing technology ensures the best consistency, in both weldability and feedability. The cleanliness of Postalloy® Hardband BU-MCG contributes to low subsurface porosity and the elimination of lack of fusion or “cold laps”. Deposits are crack-free, can be readily machined with high speed and carbide tools and can be flame or plasma cut.

Tensile Strength.....91,800 PSI

RECOMMENDED PREHEAT TEMPERATURES

*This is Tool Joint outside diameter - not Pipe or Tube outside diameter.

Tool Joint* OD (Inches)	Preheat Temperatures	
	°F	°C
2-3/8 to 3-1/8 Tubing Connection	225	107
3-1/8 to 4-3/4	225 to 300	107 to 149
4-3/4 to 5-1/2	300 to 400	149 to 204
5-1/2 to 6-3/8	400 to 500	204 to 260
6-3/8 to 7	500 to 600	260 to 316
7 to 7-1/2	600 to 650	316 to 343
8 to 8-1/2	650 to 700	343 to 371
8 to 8-1/2 (W 5" ID)	550 to 600	288 to 316

The Ultimate Build-Up Wire



TYPICAL WELDING PARAMETERS

Polarity: Electrode Positive - DCEP/Reverse

Amperage: 325 (300 to 365)

Volts: 31 (29 to 33)

Gas Mix: 98% Argon/2% Oxygen
(100% Argon, 95/5)

Flow Rate: 35 CFH (16.5 LPM) 32-37 CFH
(15-17.5 LPM)

TORCH

Angle: 12° (10° to 15°)

Offset: 1" (25mm) (3/4 to 1-1/2" 19-38mm)

Stickout: 1" (25mm) (3/4 to 1-1/8" 19-28.5mm)

OSCILLATION

Width: 1" (25mm) (3/4 to 1-1/4" 19-32mm)

Speed: 60 per minute (60 to 80)

Tie-Ins: Use 10% to 15% Bead Overlap

Preheat: (see table)

Max Interpass Temperature: 850°F (454°C)

Slow Cooling: Cover immediately after welding with a Postle HB Insulator or cooling can

Adjust parameters to achieve best band profile