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HARDBANDING SOLUTIONS by POSTLE INDUSTRIES

Hardbanding Wire

Data Sheet

POSTALLOY® TUFFBAND®NC

Description

Postalloy® Tuffband®NC is a high hardness hardband that may be used by itself for casing friendly hardband applications or used as a weld matrix with Tungsten Carbide (WC) when casing protection is not a factor.

- **Ideal for Sour Gas Service Environments**

Casing Friendly

Hardbanding deposits are NON CRACKING, providing proper preheat, interpass and cooling temperature procedures are followed. The microstructure consists of a hard, but tough tool steel matrix with approximately 55Rc hardness. Deposits are extremely CASING FRIENDLY. Tuffband®NC can be applied over itself without removal, but only if the surface has been properly cleaned and inspected. Tuffband® NC can be applied over certain previously hardbanded competitive products providing that the worn deposit is 1/32" thick or less.

NS-1 LEVEL 2 PRODUCT

NS-1 Process LEVEL 2

Tuffband®NC is Fearnley Procter NS-1™ Product Certified for New Hardbanding Applications and Process Certified for Re-applications Over Many Competitive Products.

Tungsten Carbide With Tuffband®NC

When Tuffband®NC is used as a "matrix" wire in combination with WC, the weld puddle is fluid and larger than conventional hardfacing wires, thereby allowing the WC bits to be completely consumed. There is no WC residue left on the deposits as is sometimes seen with mild steel and other matrix wires. This means that deposits are filled to the maximum and provide the ultimate in wear resistance. The resulting microstructure is a combination of tool steel and WC having a hardness of about 60Rc.

Packaging: 50 lb Spools Standard
Other packaging available upon request

APPLICATION PARAMETERS

Diameter: 1/16" (1.6mm)
Polarity: Electrode Positive - DCEP/Reverse
Amperage: 330 (300 to 365)
Volts: 30 (28 to 33)
Gas Mix: 98% Argon/2% Oxygen (100% Argon, 95/5)
Gas Flow Rate: 35 CFH (16.5 LPM) (32 to 37 15-17.5 LPM)
Torch Angle: 15° (10° to 17°)
Stickout: 1" (25mm) (3/4 to 1-1/8" 19-28.5mm)
Preheat: 225°F to 700°F (107°C to 371°C) Dependent on OD
Max Interpass Temperature: 850°F (454°C)
Slow Cooling: Cover immediately with Postle HB Insulator or cooling can

Postalloy®