HBS Bulletin

HARDBANDING SOLUTIONS by POSTLE INDUSTRIES

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Next Step, Following Up

Even pipe hardbanded with Duraband can have some issues if the hardbanding was not done correctly. Hardbanding is not a complex process but that doesn't mean that following the proper parameters and procedures aren't important. In fact, following the proper parameters and procedures *is very* important.

Ensuring that the old hardbanding is ready to be re-hardbanded is the 1st step. A good inspection and then a cleanup with a grinder are important. After that is a good deep-soaking preheating. Getting these first steps right is frequently a problem. Both take time, and some times applicators are wanting to get as much done as quickly as possible, so corners are cut.

In the actual application there are certain parameters that ensure good, smooth, uniform bands. Bands that are well tied-in and are the proper shape and dimension. Sometimes equipment can be out of calibration or have a malfunction. Incorrect torch angle or voltage and amperage settings also dramatically affect the outcome of the hardbanding. And once the bands are complete, a quick inspection and prompt and adequate control of the cooling process is also critical.

While most applicators do a very good job, there are still some that miss some of the important steps. Making sure that applicators are trained and certified is a good start in ensuring good work. However, there are still some who cut corners, or may not fully understand the importance of each critical step.

Standard Operating Procedures

Having a written SOP is important, and a good way to ensure that the hardbanding is done properly. It's always helpful for each drilling contractor and operating company to have their own SOP to define their hardbanding preferences. This can eliminate any future misunderstandings. While manufacturers have their own guidelines and specifications, some companies have preferences that should be noted. Some companies, for example, allow partial banding and others do not. Some companies have their own specifications on the height of the hardbands. While most companies want three 1" bands closely tied in, others may accept four ¾" bands. It's a good idea to have an SOP to avoid confusion and to ensure their preferences and expectations are met. Postle can help create a custom SOP for hardbanding which will list the acceptable parameters, have photos and any pertinent details.

Following Up

Postle's Site Inspections are an ideal way to ensure that everything is done properly. It's a hands-on and eyes-on process whereby all the critical parameters are checked. Here's how it works.

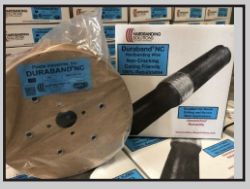
Postle is contacted by the operating company representative, drilling contractor, or hardbanding company requesting a Site Inspection. A Postle representative will go to the location where the work is being performed and witness the application. Data on the application will be recorded on a PQR (Procedure Qualification Record). This includes all the welding parameters, measurements of the bands produced, photos, lot numbers, and any additional pertinent information. This information is then provided to everyone involved in the process. Non-Compliance issues will be included, along with any Corrective Action that might be required.
It's an excellent communication tool to help any hardbander who is having difficulties or has wandered outside of acceptable parameters. It's also a good assurance to the pipe owner that his very valuable asset is being properly protected.

Best of all is that it is complementary. It's part of the service provided for being a Duraband user.

The drill string is the most expensive component of the drilling process, and its also the one that wears out the quickest. Good hardbanding, properly applied is the best way to protect that investment. We have qualified technical representatives in the field who are there to help. Just give us a call...

Welding Tip:

Proper Wire Storage



Always store wire in a clean, dry location away from rain and snow. All spools of Postle products are packaged in a sealed plastic bag with a dessicant pack prior to boxing. Once that plastic bag is opened, there is no longer protection against rust. We highly suggest saving the plastic bag and dessicant pack until the spool and been used up. If for some reason you need to store the partial spool, return it to the plastic bag and use a zip tie or tape to seal the bag. Moisture and rust are not good when welding and could create porosity and other issues during application.