

## Drill Pipe Tool Joint Rebuilding

As the cost of new drill pipe increases along with lead times, many are finding the need to pull old pipe out of the weeds and make it useable again. The rebuilding of tong spaces on a tool joint box or pin is quite similar to traditional hardbanding applications. **Postalloy Tool Joint BU-MCG** was designed to make the re-building process easy when done properly with our basic application requirements. Careful attention to preheating procedures and temperatures, as well as, slow cooling during post-welding procedures is critical. Particular attention should be given to inspection of services for cracks using MPI methods. Some adjustments will be required to accommodate various diameters of tool joints.



Re-built Tool Joint prior to machining



Re-built Tool Joints after machining

**\*Please note that this procedure will be harmful to the threads of the tool joint and re-cutting of**

If you prefer to build up with submerged arc welding, our **Tool Joint BU-SA** is the ideal product. As with our **Tool Joint BU-MCG**, deposits are crack-free and can be readily machined with high speed or carbide tools and can be flame or plasma cut.

Contact your Postle support person or Tech Center for procedure details and training.

## Beware of Counterfeits

Its been brought to our attention once again that there are some applicators applying unknown products in place of Duraband and telling customers that its either Duraband or just like Duraband. Passing-Off or making some false representations is against Federal Law. Be sure you are getting what you pay for.

- Most reputable hardband wire suppliers will supply wire in a custom printed box with lot numbers clearly identified on spools and boxes.
- Be sure to check the spools because some of the hardbanding applicators have been known to supply lower grade wires in Duraband boxes.



Front of box and spool with label



Side of box showing label with diameter, weight and lot number

Be aware that bait 'n' switching may be taking place and if you have any questions, contact Postle Industries or your Postle Tech Center for product verification.

**Got a question regarding hardbanding?**

Does Postle Ind. as a manufacturer of hardbanding wire require the documenting of repairs and hardbanding done on tool joints and if so, what should be recorded?

**Email or call  
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Keeping a record of work done on tool joints or drilling components is not required by us, but may be required by the pipe owner. We do, however, HIGHLY recommend keeping good records. A sample of an Application Log is attached for your review. Serial number, condition of the internal protective coating & existing hardbanding, preheat & interpass temperatures, wire lot number, tool joint O.D., finished hardband O.D. should be recorded at a minimum.