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Data Sheet

# Hardbanding Wire

## POSTALLOY<sup>®</sup> ULTRABAND<sup>™</sup> NM Patent Pending

### Description

**Ultraband<sup>™</sup>NM** is a hard, 100% crack free Hardband designed for non-mag drill collars and related components. Control of critical elements has resulted in a hardband alloy that meets magnetic permeability specifications and offers substantially improved wear resistance compared to conventional non-mag welding alloys, like 310 stainless – a 400% to 500% improvement. In addition, the abrasion resistance of **Ultraband<sup>™</sup>NM** is 400% to 500% better than drill collar base materials.

- Use on non-mag base materials such as P530, AG17, 15-15LC, NMS-100 and others.
- Meets all requirements of API Specification 7 - Relative Permeability – less than 1.01  
All tests are carried out according to ASTM A342 Method 3.
- It can be applied in multiple layers without spalling providing the interpass temperatures are properly controlled.
- Non-cracking
- Hardness 40 Rc

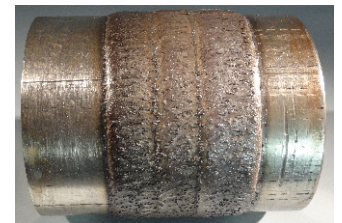
For oil and gas industry applications such as non – magnetic drill collars, stabilizers and MWD/LWD drilling tools and related components - optimized for improved wear resistance.

**Ultraband<sup>™</sup>NM** can be used by itself, or alternatively, a non-magnetic “cast tungsten carbide” may be dropped into the weld for additional wear protection. **Ultraband<sup>™</sup>NM** can be applied over previous layers of 310 stainless. Deposits are smooth and free of any slag. Re-application is easy providing the worn deposit is clean and free of defects

Please contact our Engineering Department for complete procedures.



Ultraband<sup>™</sup>NM

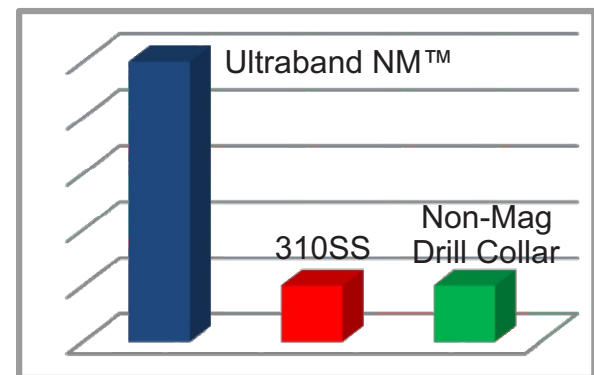


Ultraband<sup>™</sup>NM  
w/ Tungsten Carbide

### Welding Parameters

Diameter	1/16" (1.6mm)
Polarity	Electrode Positive
Gas	98% Argon/2% Oxygen
Gas Flow	32 - 37 CFH (Typical 35 CFH)
Current <i>amps</i>	220-290 (Typical 240A)
Voltage <i>volts</i>	28-32 (Typical 30V)
Wire Speed (ipm)	280-330 (Typical 315 ipm)
Stickout <i>inch (mm)</i>	3/4"-1" (18-252mm) (Typical 7/8" or 21mm)
Preheat	None - weld at room temperature
Maximum Interpass	400 °F (204°C)
Post Welding	Slow Cool to Room Temp

**Packaging** 25 Lb. Spools



Wear Rating

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