

POSTALLOY® TUFFBAND® NC

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.

APPLICATION

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.

SPECIFICATION

RECOMMENDED WELDING PARAMETERS:

Diameter	1/16" (1.6mm)
Polarity	Reverse (DCEP)
Voltage	30 (29 to 33)
Amperage	330 (300 to 380)
Shielding Gas	98% Argon/2% Oxygen
Flow	35 CFH (32 to 37)
Stick-Out	1" (25mm)
Offset	1" (25mm)
Oscillation Width	1" (25mm)
Oscillation Speed	80 per min (60 to 100)
Preheat	350/450F
Interpass	800F
Post Welding	Slow Cool to Room Temp

PACKAGING

50 lb. Spools are the standard packaging for Duraband NC. Other packaging available upon request. Please call for more information.



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