

# POSTALLOY<sup>®</sup> TOOL JOINT

Postalloy Tool Joint BU SA is a premium medium manganese, carbon steel metal cored wire for submerged arc welding with a very smooth arc transfer.

## APPLICATION

This wire is intended for multi-layer build-up of oil drilling tool joints, where compatibility with higher carbon steel chemistries is critical. Modern manufacturing technology ensures the best consistency, in both weldability and feedability. The cleanliness of Postalloy Tool Joint BU SA contributes to low subsurface porosity, and the elimination of lack of fusion or “cold laps.” Deposits are crack-free, can be readily machined with high speed and carbide tools, and can be flame cut or plasma cut.

## SPECIFICATION

### RECOMMENDED WELDING PARAMETERS

|                       |                       |
|-----------------------|-----------------------|
| <b>Diameter</b>       | 1/8" (3.2mm)          |
| <b>Voltage</b>        | 30 - 32               |
| <b>Current</b>        | 350 - 400             |
| <b>Wire Extension</b> | 1" - 1.5"             |
| <b>Flux Type</b>      | Lincoln 860, 802, 804 |
| <b>Position</b>       | Flat                  |



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