

POSTALLOY® ULTRABAND™ NM

Ultraband™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™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

APPLICATION

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™NM can be applied directly on to non-mag tools and over previous layers of 310 stainless. Used by itself, Ultraband™NM provides excellent wear resistance. For additional wear protection, a non-magnetic “cast tungsten carbide” may be dropped into the weld. Recommended size is 20-30 or 30-40 mesh at a drop rate of approximately 40 grams per minute. 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.

SPECIFICATION

RECOMMENDED WELDING PARAMETERS:

Diameter	1/16” (1.6mm)
Polarity	Electrode Positive
Voltage	30 (28 to 32)
Current	240 (220 to 290)
Shielding Gas	98% Argon/2% Oxygen
Flow	35 CFH (32 to 37)
Stick-Out	3/4' - 1" (18 to 25mm)
Offset	1" (25mm)
Preheat	Room Temperature - 100°F min. required
Interpass	400°F Max.
Post Welding	Slow Cool to Room Temp

PACKAGING

25 lb. Spools are the standard packaging for Ultraband™ NM. Other packaging available upon request. Please call for more information.



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