

## Technical data sheet

EN270623GB

# PREMIUM HARDBANDING CORED WIRES DRILL-GUARD Nb SEAMLESS



Founded in 1966, Welding Alloys Group is the global specialist in alloyed cored welding wires. Each of our DRILL-GUARD SEAMLESS hardbanding wires are developed from extensive knowledge and technical expertise. The new advanced seamless range is hermetically sealed by laser which provides outstanding welding performance.

DRILL-GUARD® the ultimate wear protection for your drill string and casing

### Best in Class: Welding operator appeal

- Needs neither special storage conditions nor re-drying prior to use
- Hermetically sealed and resistant to moisture pick up
- Ideal for outdoor jobs where climates can be challenging
- Optimal protection against cold cracking (HDM <4ml/100gr)
- Outstanding wire feeding properties
- No copper coating - better for the welder, better for the environment
- High quality overlay, smooth deposit
- Operator appeal
- High grade raw materials / alloying elements
- Excellent wear performance
- Crack-free, non-spalling or flaking
- Re-applicable
- Casing friendly
- Niobium, vanadium, and titanium carbides

### API® Standard 7CW Wear Test

Casing Wear Factor:

0.91 10<sup>-10</sup> psi<sup>-1</sup>

Frictional Factor: 0.33

Hardband O.D. Loss: 0.002 in

Tool Joint Weight Loss: 0.010 lbs



Hardness: 58 to 61 Rockwell "C"

### Hardbanding Parameters

Wire Diameter:	1/16" (1.6mm)
Current / Polarity:	DCEP / Reverse
Shielding Gas(es):	98% Ar - 2% O <sub>2</sub>
Gas Flow: Rate:	35 CFH (16.5 LPM)
Welding Amps:	260 to 305 amps (290 amps recommended)
Welding Voltage:	26 to 29 volts (29 volts recommended)
Wire Stickout "S":	0.75" to 1.25" (19mm to 32mm), from contact tip
Torch Angle "A":	5 deg. to 20 deg.
Torch Offset "O":	0.375" to 1.5" (10mm to 38mm), depends on O.D.
Oscillation Width:	0.75" to 1.0" (19mm to 25mm), depends on O.D.
Oscillation Speed:	45 to 65 cycles per minute
Spindle Speed:	See Chart, depends on O.D.
Preheat:	See Charts, depends on O.D. and drilling tool
Interpass Temp:	Maximum 850°F (454°C)
*May use a grinder on the surface after temperature is below 100°F (38°C)*	

### Support:

With over 50 years experience and operations in 28 countries, the Welding Alloys Group, fully supports their products and end-users by providing technical support within the field as well as in the office and training centers.

For technical expertise, contact:

sales@drill-guard.com

or

www.drill-guard.com

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application. Drill-Guard is a registered trademark of the Welding Alloys Group. \*Fearnley Procter NS-1™ Level 3, Uses: Initial Application of Tool Joints.