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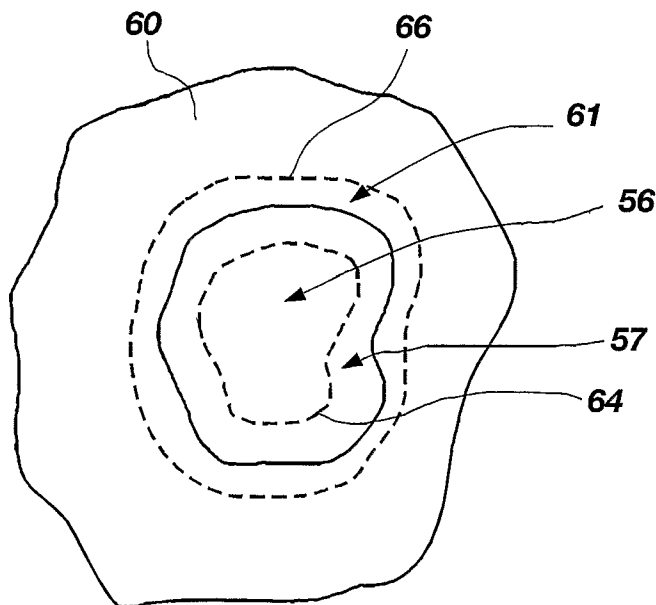
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(54) Title: COMPOSITE MATERIALS INCLUDING NICKEL-BASED MATRIX MATERIALS AND HARD PARTICLES, TOOLS INCLUDING SUCH MATERIALS, AND METHODS OF USING SUCH MATERIALS



(57) Abstract: An abrasive wear-resistant material includes a matrix and sintered and cast tungsten carbide granules. A device for use in drilling subterranean formations includes a first structure secured to a second structure with a bonding material. An abrasive wear-resistant material covers the bonding material. The first structure may include a drill bit body and the second structure may include a cutting element. A method for applying an abrasive wear-resistant material to a drill bit includes providing a bit, mixing sintered and cast tungsten carbide granules in a matrix material to provide a pre-application material, heating the pre-application material to melt the matrix material, applying the pre-application material to the bit, and solidifying the material. A method for securing a cutting element to a bit body includes providing an abrasive wear-resistant material to a surface of drill bit that covers a brazing alloy disposed between the cutting element and the bit body.

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COMPOSITE MATERIALS INCLUDING NICKEL-BASED MATRIX MATERIALS
AND HARD PARTICLES, TOOLS INCLUDING SUCH MATERIALS, AND
METHODS OF USING SUCH MATERIALS

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TECHNICAL FIELD

The present invention generally relates to earth-boring drill bits and other tools that may be used to drill subterranean formations, and to abrasive, wear-resistant hardfacing materials that may be used on surfaces of such earth-boring drill bits. The present invention also relates to methods for applying abrasive wear-resistant hardfacing materials to surfaces of earth-boring drill bits, and to methods for securing cutting elements to an earth-boring drill bit.

BACKGROUND

A typical fixed-cutter, or "drag," rotary drill bit for drilling subterranean formations includes a bit body having a face region thereon carrying cutting elements for cutting into an earth formation. The bit body may be secured to a hardened steel shank having a threaded pin connection for attaching the drill bit to a drill string that includes tubular pipe segments coupled end to end between the drill bit and other drilling equipment. Equipment such as a rotary table or top drive may be used for rotating the tubular pipe and drill bit. Alternatively, the shank may be coupled directly to the drive shaft of a down-hole motor to rotate the drill bit.

Typically, the bit body of a drill bit is formed from steel or a combination of a steel blank embedded in a matrix material that includes hard particulate material, such as tungsten carbide, infiltrated with a binder material such as a copper alloy. A steel shank may be secured to the bit body after the bit body has been formed. Structural features may be provided at selected locations on and in the bit body to facilitate the drilling process. Such structural features may include, for example, radially and longitudinally extending blades, cutting element pockets, ridges, lands, nozzle displacements, and drilling fluid courses and passages. The cutting elements generally are secured within pockets that are machined into blades located on the face region of the bit body.

Generally, the cutting elements of a fixed-cutter type drill bit each include a cutting surface comprising a hard, super-abrasive material such as mutually bound particles of polycrystalline diamond. Such "polycrystalline diamond compact" (PDC) cutters have

been employed on fixed-cutter rotary drill bits in the oil and gas well drilling industries for several decades.

FIG. 1 illustrates a conventional fixed-cutter rotary drill bit 10 generally according to the description above. The rotary drill bit 10 includes a bit body 12 that is coupled to a steel shank 14. A bore (not shown) is formed longitudinally through a portion of the drill bit 10 for communicating drilling fluid to a face 20 of the drill bit 10 via nozzles 19 during drilling operations. Cutting elements 22 (typically polycrystalline diamond compact (PDC) cutting elements) generally are bonded to the bit face 20 of the bit body 12 by methods such as brazing, adhesive bonding, or mechanical affixation.

A drill bit 10 may be used numerous times to perform successive drilling operations during which the surfaces of the bit body 12 and cutting elements 22 may be subjected to extreme forces and stresses as the cutting elements 22 of the drill bit 10 shear away the underlying earth formation. These extreme forces and stresses cause the cutting elements 22 and the surfaces of the bit body 12 to wear. Eventually, the cutting elements 22 and the surfaces of the bit body 12 may wear to an extent at which the drill bit 10 is no longer suitable for use.

FIG. 2 is an enlarged view of a PDC cutting element 22 like those shown in FIG. 1 secured to the bit body 12. Cutting elements 22 generally are not integrally formed with the bit body 12. Typically, the cutting elements 22 are fabricated separately from the bit body 12 and secured within pockets 21 formed in the outer surface of the bit body 12. A bonding material 24 such as an adhesive or, more typically, a braze alloy may be used to secure the cutting elements 22 to the bit body 12 as previously discussed herein. Furthermore, if the cutting element 22 is a PDC cutter, the cutting element 22 may include a polycrystalline diamond compact table 28 secured to a cutting element body or substrate 23, which may be unitary or comprise two components bound together.

The bonding material 24 typically is much less resistant to wear than are other portions and surfaces of the drill bit 10 and of cutting elements 22. During use, small vugs, voids and other defects may be formed in exposed surfaces of the bonding material 24 due to wear. Solids-laden drilling fluids and formation debris generated during the drilling process may further erode, abrade and enlarge the small vugs and voids in the bonding material 24. The entire cutting element 22 may separate from the drill bit body 12 during a drilling operation if enough bonding material 24 is removed. Loss of a cutting element 22

during a drilling operation can lead to rapid wear of other cutting elements and catastrophic failure of the entire drill bit 10. Therefore, there is a need in the art for an effective method for preventing the loss of cutting elements during drilling operations.

5 The materials of an ideal drill bit must be extremely hard to efficiently shear away the underlying earth formations without excessive wear. Due to the extreme forces and stresses to which drill bits are subjected during drilling operations, the materials of an ideal drill bit must simultaneously exhibit high fracture toughness. In practicality, however, materials that exhibit extremely high hardness tend to be relatively brittle and do not exhibit high fracture toughness, while materials exhibiting high fracture toughness tend to
10 be relatively soft and do not exhibit high hardness. As a result, a compromise must be made between hardness and fracture toughness when selecting materials for use in drill bits.

In an effort to simultaneously improve both the hardness and fracture toughness of earth-boring drill bits, composite materials have been applied to the surfaces of drill bits
15 that are subjected to extreme wear. These composite materials are often referred to as "hard-facing" materials and typically include at least one phase that exhibits relatively high hardness and another phase that exhibits relatively high fracture toughness.

FIG. 3 is a representation of a photomicrograph of a polished and etched surface of a conventional hard-facing material. The hard-facing material includes tungsten carbide
20 particles 40 substantially randomly dispersed throughout an iron-based matrix of matrix material 46. The tungsten carbide particles 40 exhibit relatively high hardness, while the matrix material 46 exhibits relatively high fracture toughness.

Tungsten carbide particles 40 used in hard-facing materials may comprise one or more of cast tungsten carbide particles, sintered tungsten carbide particles, and
25 macrocrystalline tungsten carbide particles. The tungsten carbide system includes two stoichiometric compounds, WC and W_2C , with a continuous range of compositions therebetween. Cast tungsten carbide generally includes a eutectic mixture of the WC and W_2C compounds. Sintered tungsten carbide particles include relatively smaller particles of WC bonded together by a matrix material. Cobalt and cobalt alloys are often used as
30 matrix materials in sintered tungsten carbide particles. Sintered tungsten carbide particles can be formed by mixing together a first powder that includes the relatively smaller tungsten carbide particles and a second powder that includes cobalt particles. The powder

mixture is formed in a "green" state. The green powder mixture then is sintered at a temperature near the melting temperature of the cobalt particles to form a matrix of cobalt material surrounding the tungsten carbide particles to form particles of sintered tungsten carbide. Finally, macrocrystalline tungsten carbide particles generally consist of single
5 crystals of WC.

Various techniques known in the art may be used to apply a hard-facing material such as that represented in FIG. 3 to a surface of a drill bit. The rod may be configured as a hollow, cylindrical tube formed from the matrix material of the hard-facing material that is filled with tungsten carbide particles. At least one end of the hollow, cylindrical tube may
10 be sealed. The sealed end of the tube then may be melted or welded onto the desired surface on the drill bit. As the tube melts, the tungsten carbide particles within the hollow, cylindrical tube mix with the molten matrix material as it is deposited onto the drill bit. An alternative technique involves forming a cast rod of the hard-facing material and using either an arc or a torch to apply or weld hard-facing material disposed at an end of the rod
15 to the desired surface on the drill bit.

Arc welding techniques also may be used to apply a hard-facing material to a surface of a drill bit. For example, a plasma-transferred arc may be established between an electrode and a region on a surface of a drill bit on which it is desired to apply a hard-facing material. A powder mixture including both particles of tungsten carbide and
20 particles of matrix material then may be directed through or proximate the plasma transferred arc onto the region of the surface of the drill bit. The heat generated by the arc melts at least the particles of matrix material to form a weld pool on the surface of the drill bit, which subsequently solidifies to form the hard-facing material layer on the surface of the drill bit.

When a hard-facing material is applied to a surface of a drill bit, relatively high temperatures are used to melt at least the matrix material. At these relatively high temperatures, atomic diffusion may occur between the tungsten carbide particles and the matrix material. In other words, after applying the hard-facing material, at least some atoms originally contained in a tungsten carbide particle (tungsten and carbon for example)
25 may be found in the matrix material surrounding the tungsten carbide particle. In addition, at least some atoms originally contained in the matrix material (iron for example) may be found in the tungsten carbide particles. FIG. 4 is an enlarged view of a tungsten carbide
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particle 40 shown in FIG. 3. At least some atoms originally contained in the tungsten carbide particle 40 (tungsten and carbon for example) may be found in a region 47 of the matrix material 46 immediately surrounding the tungsten carbide particle 40. The region 47 roughly includes the region of the matrix material 46 enclosed within the phantom line 48. In addition, at least some atoms originally contained in the matrix material 46 (iron for example) may be found in a peripheral or outer region 41 of the tungsten carbide particle 40. The outer region 41 roughly includes the region of the tungsten carbide particle 40 outside the phantom line 42.

Atomic diffusion between the tungsten carbide particle 40 and the matrix material 46 may embrittle the matrix material 46 in the region 47 surrounding the tungsten carbide particle 40 and reduce the hardness of the tungsten carbide particle 40 in the outer region 41 thereof, reducing the overall effectiveness of the hard-facing material. Therefore, there is a need in the art for abrasive wear-resistant hardfacing materials that include a matrix material that allows for atomic diffusion between tungsten carbide particles and the matrix material to be minimized. There is also a need in the art for methods of applying such abrasive wear-resistant hardfacing materials, and for drill bits and drilling tools that include such materials.

DISCLOSURE OF INVENTION

In one aspect, the present invention includes an abrasive wear-resistant material that includes a matrix material, a plurality of -20 ASTM (American Society for Testing and Materials) mesh sintered tungsten carbide pellets, and a plurality of -40 ASTM mesh cast tungsten carbide granules. The tungsten carbide pellets and granules are substantially randomly dispersed throughout the matrix material. The matrix material includes at least 75% nickel by weight and has a melting point of less than about 1100°C. Each sintered tungsten carbide pellet includes a plurality of tungsten carbide particles bonded together with a binder alloy having a melting point greater than about 1200°C. In pre-application ratios, the matrix material comprises between about 20% and about 60% by weight of the abrasive wear resistant material, the plurality of sintered tungsten carbide pellets comprises between about 30% and about 55% by weight of the abrasive wear resistant material, and the plurality of cast tungsten carbide granules comprises less than about 35% by weight of the abrasive wear resistant material. In some embodiments, for example, the matrix material may include between about 20% and about 50% by weight of the abrasive wear-

resistant material, the plurality of -40 ASTM mesh cast tungsten carbide granules may include a plurality of -100 ASTM mesh cast tungsten carbide pellets, and the plurality of -100 ASTM mesh cast tungsten carbide pellets may comprise between about 15% and about 35% by weight of the abrasive wear resistant material.

5 In another aspect, the present invention includes a device for use in drilling subterranean formations. The device includes a first structure, a second structure secured to the structure along an interface, and a bonding material disposed between the first structure and the second structure at the interface. The bonding material secures the first and second structures together. The device further includes an abrasive wear-resistant
10 material disposed on a surface of the device. At least a continuous portion of the wear-resistant material is bonded to a surface of the first structure and a surface of the second structure. The continuous portion of the wear-resistant material extends at least over the interface between the first structure and the second structure and covers the bonding material. The abrasive wear-resistant material includes a matrix material having a
15 melting temperature of less than about 1100°C, a plurality of sintered tungsten carbide pellets substantially randomly dispersed throughout the matrix material, and a plurality of cast tungsten carbide granules substantially randomly dispersed throughout the matrix material.

In an additional aspect, the present invention includes a rotary drill bit for drilling
20 subterranean formations that includes a bit body and at least one cutting element secured to the bit body along an interface. As used herein, the term “drill bit” includes and encompasses drilling tools of any configuration, including core bits, eccentric bits, bicenter bits, reamers, mills, drag bits, roller cone bits, and other such structures known in the art. A brazing alloy is disposed between the bit body and the at least one cutting element at the
25 interface and secures the at least one cutting element to the bit body. An abrasive wear-resistant material that includes, in pre-application ratios, a matrix material that comprises between about 20% and about 60% by weight of the abrasive wear-resistant material, a plurality of -20 ASTM mesh sintered tungsten carbide pellets that comprises between about 30% and about 55% by weight of the abrasive wear-resistant material, and a
30 plurality of -40 ASTM mesh cast tungsten carbide granules that comprises less than about 35% by weight of the abrasive wear-resistant material. The tungsten carbide pellets and granules are substantially randomly dispersed throughout the matrix material. The matrix

material includes at least 75% nickel by weight and has a melting point of less than about 1100°C. Each sintered tungsten pellet includes a plurality of tungsten carbide particles bonded together with a binder alloy having a melting point greater than about 1200°C.

In yet another aspect, the present invention includes a method for applying an
5 abrasive wear-resistant material to a surface of a drill bit for drilling subterranean formations. The method includes providing a drill bit including a bit body having an outer surface, mixing a plurality of -20 ASTM mesh sintered tungsten carbide pellets and a plurality of -40 ASTM mesh cast tungsten carbide granules in a matrix material to provide a pre-application abrasive wear resistant material, and melting the matrix material. The
10 molten matrix material, at least some of the sintered tungsten carbide pellets, and at least some of the cast tungsten carbide granules are applied to at least a portion of the outer surface of the drill bit, and the molten matrix material is solidified. The matrix material includes at least 75% nickel by weight and has a melting point of less than about 1100°C. Each sintered tungsten pellet includes a plurality of tungsten carbide particles bonded
15 together with a binder alloy having a melting point greater than about 1200°C. The matrix material comprises between about 20% and about 60% by weight of the pre-application abrasive wear-resistant material, the plurality of sintered tungsten carbide pellets comprises between about 30% and about 55% by weight of the pre-application abrasive wear-resistant material, and the plurality of cast tungsten carbide granules comprises less than about 35%
20 by weight of the pre-application abrasive wear-resistant material. In some embodiments, mixing a plurality of -20 ASTM mesh sintered tungsten carbide pellets and a plurality of -40 ASTM mesh cast tungsten carbide granules in a matrix material may comprise mixing a plurality of -20 ASTM mesh sintered tungsten carbide pellets and a plurality of -100
25 ASTM mesh cast tungsten carbide pellets in a matrix material to provide the pre-application abrasive wear-resistant material, in which the matrix material may comprise between about 20% and about 50% by weight of the pre-application abrasive wear-resistant material, the plurality of sintered tungsten carbide pellets may comprise between about 30% and about 55% by weight of the pre-application abrasive wear-resistant material, and the plurality of cast tungsten carbide pellets may comprise between about
30 15% and about 35% by weight of the pre-application abrasive wear-resistant material.

In another aspect, the present invention includes a method for securing a cutting element to a bit body of a rotary drill bit. The method includes providing a rotary drill bit

including a bit body having an outer surface including a pocket therein that is configured to receive a cutting element, and positioning a cutting element within the pocket. A brazing alloy is provided, melted, and applied to adjacent surfaces of the cutting element and the outer surface of the bit body within the pocket defining an interface therebetween and solidified. An abrasive wear-resistant material is applied to a surface of the drill bit. At least a continuous portion of the abrasive wear-resistant material is bonded to a surface of the cutting element and a portion of the outer surface of the bit body. The continuous portion extends over at least the interface between the cutting element and the outer surface of the bit body and covers the brazing alloy. In pre-application ratios, the abrasive wear resistant material comprises a matrix material, a plurality of sintered tungsten carbide pellets, and a plurality of cast tungsten carbide granules. The matrix material includes at least 75% nickel by weight and has a melting point of less than about 1100°C. The tungsten carbide pellets are substantially randomly dispersed throughout the matrix material. Furthermore, each sintered tungsten pellet includes a plurality of tungsten carbide particles bonded together with a binder alloy having a melting point greater than about 1200°C.

The features, advantages, and alternative aspects of the present invention will be apparent to those skilled in the art from a consideration of the following detailed description considered in combination with the accompanying drawings.

BRIEF DESCRIPTION OF DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming that which is regarded as the present invention, the advantages of this invention may be more readily ascertained from the following description of the invention when read in conjunction with the accompanying drawings in which:

- FIG. 1 is a perspective view of a rotary type drill bit that includes cutting elements;
FIG. 2 is an enlarged view of a cutting element of the drill bit shown in FIG. 1;
FIG. 3 is a representation of a photomicrograph of an abrasive wear-resistant material that includes tungsten carbide particles substantially randomly dispersed throughout a matrix material;
FIG. 4 is an enlarged view of a tungsten carbide particle shown in FIG. 3;

FIG. 5 is a representation of a photomicrograph of an abrasive wear-resistant material that embodies teachings of the present invention and that includes tungsten carbide particles substantially randomly dispersed throughout a matrix;

FIG. 6 is an enlarged view of a tungsten carbide particle shown in FIG. 5

5 FIG. 7A is an enlarged view of a cutting element of a drill bit that embodies teachings of the present invention;

FIG. 7B is a lateral cross-sectional view of the cutting element shown in FIG. 7A taken along section line 7B-7B therein;

10 FIG. 7C is a longitudinal cross-sectional view of the cutting element shown in FIG. 7A taken along section line 7C-7C therein;

FIG. 8A is a lateral cross-sectional view like that of FIG. 7B illustrating another cutting element of a drill bit that embodies teachings of the present invention;

FIG. 8B is a longitudinal cross-sectional view of the cutting element shown in FIG. 8A; and

15 FIG. 9 is a photomicrograph of an abrasive wear-resistant material that embodies teachings of the present invention and that includes tungsten carbide particles substantially randomly dispersed throughout a matrix.

MODES FOR CARRYING OUT THE INVENTION

20 The illustrations presented herein, with the exception of FIG. 9, are not meant to be actual views of any particular material, apparatus, system, or method, but are merely idealized representations which are employed to describe the present invention. Additionally, elements common between figures may retain the same numerical designation.

25 FIG. 5 represents a polished and etched surface of an abrasive wear-resistant material 54 that embodies teachings of the present invention. FIG. 9 is an actual photomicrograph of a polished and etched surface of an abrasive wear-resistant material that embodies teachings of the present invention. Referring to FIG. 5, the abrasive wear-resistant material 54 includes a plurality of sintered tungsten carbide pellets 56 and a plurality of cast tungsten carbide granules 58 substantially randomly dispersed throughout a
30 matrix material 60. Each sintered tungsten carbide pellet 56 may have a generally spherical pellet configuration. The term "pellet" as used herein means any particle having a generally spherical shape. Pellets are not true spheres, but lack the corners, sharp edges,

and angular projections commonly found in crushed and other non-spherical tungsten carbide particles. In some embodiments of the present invention, the cast tungsten carbide granules may be or include cast tungsten carbide pellets, as shown in FIG. 9.

5 Corners, sharp edges, and angular projections may produce residual stresses, which may cause tungsten carbide material in the regions of the particles proximate the residual stresses to melt at lower temperatures during application of the abrasive wear-resistant material 54 to a surface of a drill bit. Melting or partial melting of the tungsten carbide material during application may facilitate atomic diffusion between the tungsten carbide particles and the surrounding matrix material. As previously discussed herein, atomic
10 diffusion between the matrix material 60 and the sintered tungsten carbide pellets 56 and cast tungsten carbide granules 58 may embrittle the matrix material 60 in regions surrounding the tungsten carbide pellets 56, 58 and reduce the hardness of the tungsten carbide pellets 56, 58 in the outer regions thereof. Such atomic diffusion may degrade the overall physical properties of the abrasive wear-resistant material 54. The use of sintered
15 tungsten carbide pellets 56 (and, optionally, cast tungsten carbide pellets 58) instead of conventional tungsten carbide particles that include corners, sharp edges, and angular projections may reduce such atomic diffusion, thereby preserving the physical properties of the matrix material 60 and the sintered tungsten carbide pellets 56 (and, optionally, the cast tungsten carbide pellets 58) during application of the abrasive wear-resistant material 54 to
20 the surfaces of drill bits and other tools.

 The matrix material 60 may comprise between about 20% and about 60% by weight of the abrasive wear-resistant material 54. In some embodiments, the matrix material 60 may comprise between about 30% and about 50% by weight of the abrasive wear-resistant material 54. More particularly, the matrix material 60 may comprise between about 35%
25 and about 45% by weight of the abrasive wear-resistant material 54. The plurality of sintered tungsten carbide pellets 56 may comprise between about 30% and about 55% by weight of the abrasive wear-resistant material 54. Furthermore, the plurality of cast tungsten carbide granules 58 may comprise less than about 35% by weight of the abrasive wear-resistant material 54. More particularly, the plurality of cast tungsten carbide
30 granules 58 may comprise between about 10% and about 35% by weight of the abrasive wear-resistant material 54. For example, the matrix material 60 may be about 40% by weight of the abrasive wear-resistant material 54, the plurality of sintered tungsten carbide

pellets 56 may be about 48% by weight of the abrasive wear-resistant material 54, and the plurality of cast tungsten carbide granules 58 may be about 12% by weight of the abrasive wear-resistant material 54. In additional embodiments, the plurality of cast tungsten carbide granules 58 may comprise between about 15% and about 35% by weight of the abrasive wear-resistant material 54.

The sintered tungsten carbide pellets 56 may be larger in size than the cast tungsten carbide granules 58. Furthermore, the number of cast tungsten carbide granules 56 per unit volume of the abrasive wear-resistant material 54 may be higher than the number of sintered tungsten carbide pellets 58 per unit volume of the abrasive wear-resistant material 54.

The sintered tungsten carbide pellets 56 may include -20 ASTM mesh pellets. As used herein, the phrase "-20 ASTM mesh pellets" means pellets that are capable of passing through an ASTM No. 20 U.S.A. standard testing sieve. Such sintered tungsten carbide pellets may have an average diameter of less than about 850 microns. The average diameter of the sintered tungsten carbide pellets 56 may be between about 1.1 times and about 5 times greater than the average diameter of the cast tungsten carbide granules 58. The cast tungsten carbide granules 58 may include -40 ASTM mesh granules. As used herein, the phrase "-40 ASTM mesh granules" means granules that are capable of passing through an ASTM No. 40 U.S.A. standard testing sieve. In some embodiments, the cast tungsten carbide granules 58 may include -100 ASTM mesh cast tungsten carbide pellets. As used herein, the phrase "-100 ASTM mesh pellets" means pellets that are capable of passing through an ASTM No. 100 U.S.A. standard testing sieve. Such cast tungsten carbide granules may have an average diameter of less than about 150 microns.

As an example, the sintered tungsten carbide pellets 56 may include -60/+80 ASTM mesh pellets, and the cast tungsten carbide granules 58 may include -100/+270 ASTM mesh granules. As used herein, the phrase "-60/+80 ASTM mesh pellets" means pellets that are capable of passing through an ASTM No. 60 U.S.A. standard testing sieve, but incapable of passing through an ASTM No. 80 U.S.A. standard testing sieve. Such sintered tungsten carbide pellets may have an average diameter of less than about 250 microns and greater than about 180 microns. Furthermore, the phrase "-100/+270 ASTM mesh granules," as used herein, means granules capable of passing through an ASTM No. 100 U.S.A. standard testing sieve, but incapable of passing through an ASTM No. 270

U.S.A. standard testing sieve. Such cast tungsten carbide granules 58 may have an average diameter in a range from approximately 50 microns to about 150 microns.

As another example, the plurality of sintered tungsten carbide pellets 56 may include a plurality of -60/+80 ASTM mesh sintered tungsten carbide pellets and a plurality of -120/+270 ASTM mesh sintered tungsten carbide pellets. The plurality of -60/+80 ASTM mesh sintered tungsten carbide pellets may comprise between about 30% and about 40% by weight of the abrasive wear-resistant material 54, and the plurality of -120/+270 ASTM mesh sintered tungsten carbide pellets may comprise between about 15% and about 25% by weight of the abrasive wear-resistant material 54. As used herein, the phrase “-120/+270 ASTM mesh pellets,” as used herein, means pellets capable of passing through an ASTM No. 120 U.S.A. standard testing sieve, but incapable of passing through an ASTM No. 270 U.S.A. standard testing sieve. Such sintered tungsten carbide pellets 56 may have an average diameter in a range from approximately 50 microns to about 125 microns.

In one particular embodiment, set forth merely as an example, the abrasive wear-resistant material 54 may include about 40% by weight matrix material 60, about 48% by weight -20/+30 ASTM mesh sintered tungsten carbide pellets 56, and about 12% by weight -140/+325 ASTM mesh cast tungsten carbide granules 58. As used herein, the phrase “-20/+30 ASTM mesh pellets” means pellets that are capable of passing through an ASTM No. 20 U.S.A. standard testing sieve, but incapable of passing through an ASTM No. 30 U.S.A. standard testing sieve. Similarly, the phrase “-140/+325 ASTM mesh pellets” means pellets that are capable of passing through an ASTM No. 140 U.S.A. standard testing sieve, but incapable of passing through an ASTM No. 325 U.S.A. standard testing sieve. The matrix material 60 may include a nickel-based alloy, which may further include one or more additional elements such as, for example, chromium, boron, and silicon. The matrix material 60 also may have a melting point of less than about 1100 °C; and may exhibit a hardness of between about 35 and about 60 on the Rockwell C Scale. More particularly, the matrix material 60 may exhibit a hardness of between about 40 and about 55 on the Rockwell C Scale. For example, the matrix material 60 may exhibit a hardness of about 40 on the Rockwell C Scale.

Cast granules and sintered pellets of carbides other than tungsten carbide also may be used to provide abrasive wear-resistant materials that embody teachings of the present

invention. Such other carbides include, but are not limited to, chromium carbide, molybdenum carbide, niobium carbide, tantalum carbide, titanium carbide, and vanadium carbide.

The matrix material 60 may comprise a metal alloy material having a melting point that is less than about 1100° C. Furthermore, each sintered tungsten carbide pellet 56 of the plurality of sintered tungsten carbide pellets 56 may comprise a plurality of tungsten carbide particles bonded together with a binder alloy having a melting point that is greater than about 1200° C. For example, the binder alloy may comprise a cobalt-based metal alloy material or a nickel-based alloy material having a melting point that is greater than about 1200° C. In this configuration, the matrix material 60 may be substantially melted during application of the abrasive wear-resistant material 54 to a surface of a drilling tool such as a drill bit without substantially melting the cast tungsten carbide granules 58, or the binder alloy or the tungsten carbide particles of the sintered tungsten carbide pellets 56. This enables the abrasive wear-resistant material 54 to be applied to a surface of a drilling tool at lower temperatures to minimize atomic diffusion between the sintered tungsten carbide pellets 56 and the matrix material 60 and between the cast tungsten carbide granules 58 and the matrix material 60.

As previously discussed herein, minimizing atomic diffusion between the matrix material 60 and the sintered tungsten carbide pellets 56 and cast tungsten carbide granules 58, helps to preserve the chemical composition and the physical properties of the matrix material 60, the sintered tungsten carbide pellets 56, and the cast tungsten carbide granules 58 during application of the abrasive wear-resistant material 54 to the surfaces of drill bits and other tools.

The matrix material 60 also may include relatively small amounts of other elements, such as carbon, chromium, silicon, boron, iron, and nickel. Furthermore, the matrix material 60 also may include a flux material such as silicomanganese, an alloying element such as niobium, and a binder such as a polymer material.

FIG. 6 is an enlarged view of a sintered tungsten carbide pellet 56 shown in FIG. 5. The hardness of the sintered tungsten carbide pellet 56 may be substantially consistent throughout the pellet. For example, the sintered tungsten carbide pellet 56 may include a peripheral or outer region 57 of the sintered tungsten carbide pellet 56. The outer region 57 may roughly include the region of the sintered tungsten carbide pellet 56 outside the

phantom line 64. The sintered tungsten carbide pellet 56 may exhibit a first average hardness in the central region of the pellet enclosed by the phantom line 64, and a second average hardness at locations within the peripheral region 57 of the pellet outside the phantom line 64. The second average hardness of the sintered tungsten carbide pellet 56 may be greater than about 99% of the first average hardness of the sintered tungsten carbide pellet 56. As an example, the first average hardness may be about 91 on the Rockwell A Scale and the second average hardness may be about 90 on the Rockwell A Scale. Moreover, the fracture toughness of the matrix material 60 within the region 61 proximate the sintered tungsten carbide pellet 56 and enclosed by the phantom line 66 may be substantially similar to the fracture toughness of the matrix material 60 outside the phantom line 66.

Commercially available metal alloy materials that may be used as the matrix material 60 in the abrasive wear-resistant material 54 are sold by Broco, Inc., of Rancho Cucamonga, California under the trade names VERSALLOY® 40 and VERSALLOY® 50. Commercially available sintered tungsten carbide pellets 56 and cast tungsten carbide granules 58 that may be used in the abrasive wear-resistant material 54 are sold by Sulzer Metco WOKA GmbH, of Barchfeld, Germany.

The sintered tungsten carbide pellets 56 may have relatively high fracture toughness relative to the cast tungsten carbide granules 58, while the cast tungsten carbide granules 58 may have relatively high hardness relative to the sintered tungsten carbide pellets 56. By using matrix materials 60 as described herein, the fracture toughness of the sintered tungsten carbide pellets 56 and the hardness of the cast tungsten carbide granules 58 may be preserved in the abrasive wear-resistant material 54 during application of the abrasive wear-resistant material 54 to a drill bit or other drilling tool, thereby providing an abrasive wear-resistant material 54 that is improved relative to abrasive wear-resistant materials known in the art.

Abrasive wear-resistant materials that embody teachings of the present invention, such as the abrasive wear-resistant material 54 illustrated in FIGS. 5-6, may be applied to selected areas on surfaces of rotary drill bits (such as the rotary drill bit 10 shown in FIG. 1), rolling cutter drill bits (commonly referred to as "roller cone" drill bits), and other drilling tools that are subjected to wear such as ream-while-drilling tools and expandable

reamer blades, all such apparatuses and others being encompassed, as previously indicated, within the term "drill bit."

Certain locations on a surface of a drill bit may require relatively higher hardness, while other locations on the surface of the drill bit may require relatively higher fracture toughness. The relative weight percentages of the matrix material 60, the plurality of sintered tungsten carbide pellets 56, and the plurality of cast tungsten carbide granules 58 may be selectively varied to provide an abrasive wear-resistant material 54 that exhibits physical properties tailored to a particular tool or to a particular area on a surface of a tool. For example, the surfaces of cutting teeth on a rolling cutter type drill bit may be subjected to relatively high impact forces in addition to frictional-type abrasive or grinding forces. Therefore, abrasive wear-resistant material 54 applied to the surfaces of the cutting teeth may include a higher weight percentage of sintered tungsten carbide pellets 56 in order to increase the fracture toughness of the abrasive wear-resistant material 54. In contrast, the gage surfaces of a drill bit may be subjected to relatively little impact force but relatively high frictional-type abrasive or grinding forces. Therefore, abrasive wear-resistant material 54 applied to the gage surfaces of a drill bit may include a higher weight percentage of cast tungsten carbide granules 58 in order to increase the hardness of the abrasive wear-resistant material 54.

In addition to being applied to selected areas on surfaces of drill bits and drilling tools that are subjected to wear, the abrasive wear-resistant materials that embody teachings of the present invention may be used to protect structural features or materials of drill bits and drilling tools that are relatively more prone to wear.

A portion of a representative rotary drill bit 50 that embodies teachings of the present invention is shown in FIG. 7A. The rotary drill bit 50 is structurally similar to the rotary drill bit 10 shown in FIG. 1, and includes a plurality of cutting elements 22 positioned and secured within pockets provided on the outer surface of a bit body 12. As illustrated in FIG. 7A, each cutting element 22 may be secured to the bit body 12 of the drill bit 50 along an interface therebetween. A bonding material 24 such as, for example, an adhesive or brazing alloy may be provided at the interface and used to secure and attach each cutting element 22 to the bit body 12. The bonding material 24 may be less resistant to wear than the materials of the bit body 12 and the cutting elements 22. Each cutting

element 22 may include a polycrystalline diamond compact table 28 attached and secured to a cutting element body or substrate 23 along an interface.

The rotary drill bit 50 further includes an abrasive wear-resistant material 54 disposed on a surface of the drill bit 50. Moreover, regions of the abrasive wear-resistant material 54 may be configured to protect exposed surfaces of the bonding material 24.

FIG. 7B is a lateral cross-sectional view of the cutting element 22 shown in FIG. 7A taken along section line 7B-7B therein. As illustrated in FIG. 7B, continuous portions of the abrasive wear-resistant material 54 may be bonded both to a region of the outer surface of the bit body 12 and a lateral surface of the cutting element 22 and each continuous portion may extend over at least a portion of the interface between the bit body 12 and the lateral sides of the cutting element 22.

FIG. 7C is a longitudinal cross-sectional view of the cutting element 22 shown in FIG. 7A taken along section line 7C-7C therein. As illustrated in FIG. 7C, another continuous portion of the abrasive wear-resistant material 54 may be bonded both to a region of the outer surface of the bit body 12 and a lateral surface of the cutting element 22 and may extend over at least a portion of the interface between the bit body 12 and the longitudinal end surface of the cutting element 22 opposite the a polycrystalline diamond compact table 28. Yet another continuous portion of the abrasive wear-resistant material 54 may be bonded both to a region of the outer surface of the bit body 12 and a portion of the exposed surface of the polycrystalline diamond compact table 28 and may extend over at least a portion of the interface between the bit body 12 and the face of the polycrystalline diamond compact table 28.

In this configuration, the continuous portions of the abrasive wear-resistant material 54 may cover and protect at least a portion of the bonding material 24 disposed between the cutting element 22 and the bit body 12 from wear during drilling operations. By protecting the bonding material 24 from wear during drilling operations, the abrasive wear-resistant material 54 helps to prevent separation of the cutting element 22 from the bit body 12 during drilling operations, damage to the bit body 12, and catastrophic failure of the rotary drill bit 50.

The continuous portions of the abrasive wear-resistant material 54 that cover and protect exposed surfaces of the bonding material 24 may be configured as a bead or beads

of abrasive wear-resistant material 54 provided along and over the edges of the interfacing surfaces of the bit body 12 and the cutting element 22.

5 A lateral cross-sectional view of a cutting element 22 of another representative rotary drill bit 50' that embodies teachings of the present invention is shown in FIGS. 8A and 8B. The rotary drill bit 50' is structurally similar to the rotary drill bit 10 shown in FIG. 1, and includes a plurality of cutting elements 22 positioned and secured within pockets provided on the outer surface of a bit body 12'. The cutting elements 22 of the rotary drill bit 50' also include continuous portions of the abrasive wear-resistant material 54 that cover and protect exposed surfaces of a bonding material 24 along the edges of the
10 interfacing surfaces of the bit body 12' and the cutting element 22, as discussed previously herein in relation to the rotary drill bit 50 shown in FIGS. 7A-7C.

As illustrated in FIG. 8A, however, recesses 70 are provided in the outer surface of the bit body 12' adjacent the pockets within which the cutting elements 22 are secured. In this configuration, bead or beads of abrasive wear-resistant material 54 may be provided
15 within the recesses 70 along the edges of the interfacing surfaces of the bit body 12 and the cutting element 22. By providing the bead or beads of abrasive wear-resistant material 54 within the recesses 70, the extent to which the bead or beads of abrasive wear-resistant material 54 protrude from the surface of the rotary drill bit 50' may be minimized. As a result, abrasive and erosive materials and flows to which the bead or beads of abrasive
20 wear-resistant material 54 are subjected during drilling operations may be reduced.

The abrasive wear-resistant material 54 may be used to cover and protect interfaces between any two structures or features of a drill bit or other drilling tool. For example, the interface between a bit body and a periphery of wear knots or any type of insert in the bit body. In addition, the abrasive wear-resistant material 54 is not limited to use at interfaces
25 between structures or features and may be used at any location on any surface of a drill bit or drilling tool that is subjected to wear.

Abrasive wear-resistant materials that embody teachings of the present invention, such as the abrasive wear-resistant material 54, may be applied to the selected surfaces of a drill bit or drilling tool using variations of techniques known in the art. For example, a
30 pre-application abrasive wear-resistant material that embodies teachings of the present invention may be provided in the form of a welding rod. The welding rod may comprise a solid cast or extruded rod consisting of the abrasive wear-resistant material 54.

Alternatively, the welding rod may comprise a hollow cylindrical tube formed from the matrix material 60 and filled with a plurality of sintered tungsten carbide pellets 56 and a plurality of cast tungsten carbide granules 58. An oxyacetylene torch or any other type of welding torch may be used to heat at least a portion of the welding rod to a temperature
5 above the melting point of the matrix material 60 and less than about 1200°C to melt the matrix material 60. This may minimize the extent of atomic diffusion occurring between the matrix material 60 and the sintered tungsten carbide pellets 56 and cast tungsten carbide granules 58.

The rate of atomic diffusion occurring between the matrix material 60 and the
10 sintered tungsten carbide pellets 56 and cast tungsten carbide granules 58 is at least partially a function of the temperature at which atomic diffusion occurs. The extent of atomic diffusion, therefore, is at least partially a function of both the temperature at which atomic diffusion occurs and the time for which atomic diffusion is allowed to occur. Therefore, the extent of atomic diffusion occurring between the matrix material 60 and the
15 sintered tungsten carbide pellets 56 and cast tungsten carbide granules 58 may be controlled by controlling the distance between the torch and the welding rod (or pre-application abrasive wear-resistant material), and the time for which the welding rod is subjected to heat produced by the torch.

Oxyacetylene and atomic hydrogen torches may be capable of heating materials to
20 temperatures in excess of 1200° C. It may be beneficial to slightly melt the surface of the drill bit or drilling tool to which the abrasive wear-resistant material 54 is to be applied just prior to applying the abrasive wear-resistant material 54 to the surface. For example, an oxyacetylene and atomic hydrogen torch may be brought in close proximity to a surface of a drill bit or drilling tool and used to heat to the surface to a sufficiently high temperature
25 to slightly melt or “sweat” the surface. The welding rod comprising pre-application wear-resistant material then may be brought in close proximity to the surface and the distance between the torch and the welding rod may be adjusted to heat at least a portion of the welding rod to a temperature above the melting point of the matrix material 60 and less than about 1200° C to melt the matrix material 60. The molten matrix material 60, at least
30 some of the sintered tungsten carbide pellets 56, and at least some of the cast tungsten carbide granules 58 may be applied to the surface of the drill bit, and the molten matrix material 60 may be solidified by controlled cooling. The rate of cooling may be controlled

to control the microstructure and physical properties of the abrasive wear-resistant material 54.

Alternatively, the abrasive wear-resistant material 54 may be applied to a surface of a drill bit or drilling tool using an arc welding technique, such as a plasma transferred arc welding technique. For example, the matrix material 60 may be provided in the form of a powder (small particles of matrix material 60). A plurality of sintered tungsten carbide pellets 56 and a plurality of cast tungsten carbide granules 58 may be mixed with the powdered matrix material 60 to provide a pre-application wear-resistant material in the form of a powder mixture. A plasma transferred arc welding machine then may be used to heat at least a portion of the pre-application wear-resistant material to a temperature above the melting point of the matrix material 60 and less than about 1200° C to melt the matrix material 60.

Plasma transferred arc welding machines typically include a non-consumable electrode that may be brought in close proximity to the substrate (drill bit or other drilling tool) to which material is to be applied. A plasma-forming gas is provided between the substrate and the non-consumable electrode, typically in the form a column of flowing gas. An arc is generated between the electrode and the substrate to generate a plasma in the plasma-forming gas. The powdered pre-application wear-resistant material may be directed through the plasma and onto a surface of the substrate using an inert carrier gas. As the powdered pre-application wear-resistant material passes through the plasma it is heated to a temperature at which at least some of the wear-resistant material will melt. Once the at least partially molten wear-resistant material has been deposited on the surface of the substrate, the wear-resistant material is allowed to solidify. Such plasma transferred arc welding machines are known in the art and commercially available.

The temperature to which the pre-application wear-resistant material is heated as the material passes through the plasma may be at least partially controlled by controlling the current passing between the electrode and the substrate. For example, the current may be pulsed at a selected pulse rate between a high current and a low current. The low current may be selected to be sufficiently high to melt at least the matrix material 60 in the pre-application wear-resistant material, and the high current may be sufficiently high to melt or sweat the surface of the substrate. Alternatively, the low current may be selected to be too low to melt any of the pre-application wear-resistant material, and the high current

may be sufficiently high to heat at least a portion of the pre-application wear-resistant material to a temperature above the melting point of the matrix material 60 and less than about 1200°C to melt the matrix material 60. This may minimize the extent of atomic diffusion occurring between the matrix material 60 and the sintered tungsten carbide pellets
5 56 and cast tungsten carbide granules 58.

Other welding techniques, such as metal inert gas (MIG) arc welding techniques, tungsten inert gas (TIG) arc welding techniques, and flame spray welding techniques are known in the art and may be used to apply the abrasive wear-resistant material 54 to a surface of a drill bit or drilling tool.

10 While the present invention has been described herein with respect to certain preferred embodiments, those of ordinary skill in the art will recognize and appreciate that it is not so limited. Rather, many additions, deletions and modifications to the preferred embodiments may be made without departing from the scope of the invention as hereinafter claimed. In addition, features from one embodiment may be combined with
15 features of another embodiment while still being encompassed within the scope of the invention as contemplated by the inventors. Further, the invention has utility in drill bits and core bits having different and various bit profiles as well as cutter types.

CLAIMS

1. An abrasive wear-resistant material comprising the following materials in pre-application ratios:
 - 5 a matrix material, the matrix material comprising between about 20% and about 60% by weight of the abrasive wear-resistant material, the matrix material comprising at least 75% nickel by weight, the matrix material having a melting point of less than about 1100 °C;
 - 10 a plurality of -20 ASTM mesh sintered tungsten carbide pellets substantially randomly dispersed throughout the matrix material, the plurality of sintered tungsten carbide pellets comprising between about 30% and about 55% by weight of the abrasive wear-resistant material, each sintered tungsten carbide pellet comprising a plurality of tungsten carbide particles bonded together with a binder alloy, the binder alloy having a melting point greater than about 1200 °C; and
 - 15 a plurality of -40 ASTM mesh cast tungsten carbide granules substantially randomly dispersed throughout the matrix material, the plurality of cast tungsten carbide pellets comprising less than about 35% by weight of the abrasive wear-resistant material.
- 20 2. The abrasive wear-resistant material of claim 1, wherein the matrix material comprises between about 20% and about 50% by weight of the abrasive wear-resistant material, the plurality of -40 ASTM mesh cast tungsten carbide granules comprises a plurality of -100 ASTM mesh cast tungsten pellets, and the plurality of -100 ASTM mesh cast tungsten pellets comprises between about 15% and about 35% by weight of the
25 abrasive wear-resistant material.
3. The abrasive wear-resistant material of claim 2, wherein the plurality of -20 ASTM mesh sintered tungsten carbide pellets comprises a plurality of -60/+80 ASTM mesh sintered tungsten carbide pellets and a plurality of -120/+270 ASTM mesh sintered
30 tungsten carbide pellets, the plurality of -60/+80 ASTM mesh sintered tungsten carbide pellets comprising between about 30% and about 35% by weight of the abrasive wear-resistant material, the plurality of -120/+270 ASTM mesh sintered tungsten carbide

pellets comprising between about 15% and about 20% by weight of the abrasive wear-resistant material.

4. The abrasive wear-resistant material of any one of claims 1 through 3,
5 wherein the abrasive wear-resistant material is disposed on a tool comprising:
a first structure;
a second structure secured to the first structure along an interface; and
a bonding material disposed between the first structure and the second structure at the
interface, the bonding material securing the first structure and the second structure
10 together; and
wherein the abrasive wear-resistant material is disposed on a surface of the tool, at least a
continuous portion of the wear-resistant material being bonded to a surface of the
first structure and a surface of the second structure and extending over the interface
between the first structure and the second structure and covering the bonding
15 material.

5. The abrasive wear-resistant material of claim 4, wherein the first structure
comprises a bit body of a rotary drill bit and the second structure comprises a cutting
element of the rotary drill bit.
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6. The abrasive wear-resistant material of claim 4 or claim 5, wherein the
bonding material comprises a brazing alloy.

7. The abrasive wear-resistant material of claim 5, wherein the bit body of the
25 rotary drill bit has an outer surface and at least one recess formed in the outer surface
adjacent the interface between the bit body and the cutting element, and wherein at least a
portion of the abrasive wear-resistant material is disposed within the at least one recess.

8. The abrasive wear-resistant material of any one of claims 5 through 7,
30 wherein the bit body of the rotary drill bit has an outer surface and a pocket therein, at least
a portion of the cutting element being disposed within the pocket, the interface extending
along adjacent surfaces of the bit body and the cutting element.

9. The abrasive wear-resistant material of any one of claims 1 through 8, wherein the abrasive wear-resistant material further comprises niobium, the niobium being less than about 1% of the abrasive wear-resistant material.

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10. The abrasive wear-resistant material of any one of claims 1 through 9, wherein the matrix material of the abrasive wear-resistant material further comprises at least one of chromium, nickel, iron, boron, and silicon.

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11. The abrasive wear-resistant material of any one of claims 3 through 10, wherein each sintered tungsten carbide pellet of the abrasive wear-resistant material has a first average hardness in a central region of the pellet and a second hardness in a peripheral region of the pellet, the second hardness being greater than about 99% of the first hardness.

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12. The abrasive wear-resistant material of any one of claim 11, wherein the first hardness and the second hardness are greater than about 89 on a Rockwell A hardness scale.

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13. A method for applying an abrasive wear-resistant material to a surface of a tool for use in drilling subterranean formations, the method comprising:

providing a tool for use in drilling subterranean formations, the tool comprising a first structure having an outer surface;

mixing a plurality of -20 ASTM mesh sintered tungsten carbide pellets and a plurality of

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-40 ASTM mesh cast tungsten carbide granules in a matrix material to provide a pre-application abrasive wear-resistant material, the matrix material comprising at least 75% nickel by weight, the matrix material having a melting point of less than about 1100 °C, each sintered tungsten carbide pellet comprising a plurality of tungsten carbide particles bonded together with a binder alloy, the binder alloy having a melting point greater than about 1200 °C, the matrix material comprising

30

between about 20% and about 60% by weight of the pre-application abrasive wear-resistant material, the plurality of sintered tungsten carbide pellets comprising between about 30% and about 55% by weight of the pre-application abrasive

wear-resistant material, the plurality of cast tungsten carbide granules comprising less than about 35% by weight of the pre-application abrasive wear-resistant material;

melting the matrix material, melting the matrix material comprising heating at least a portion of the pre-application abrasive wear-resistant material to a temperature above the melting point of the matrix material and less than about 1200°C to melt the matrix material;

applying the molten matrix material, at least some of the sintered tungsten carbide pellets, and at least some of the cast tungsten carbide granules to at least a portion of the outer surface of the first structure; and solidifying the molten matrix material.

14. The method of claim 13, wherein mixing a plurality of -20 ASTM mesh sintered tungsten carbide pellets and a plurality of -40 ASTM mesh cast tungsten carbide granules in a matrix material comprises mixing a plurality of -20 ASTM mesh sintered tungsten carbide pellets and a plurality of -100 ASTM mesh cast tungsten carbide pellets in a matrix material to provide the pre-application abrasive wear-resistant material, and wherein the matrix material comprises between about 20% and about 50% by weight of the pre-application abrasive wear-resistant material, the plurality of sintered tungsten carbide pellets comprises between about 30% and about 55% by weight of the pre-application abrasive wear-resistant material, and the plurality of cast tungsten carbide pellets comprises between about 15% and about 35% by weight of the pre-application abrasive wear-resistant material.

15. The method of claim 13 or claim 14, wherein heating at least a portion of the pre-application abrasive wear-resistant material comprises at least one of heating the matrix material with a plasma transferred arc, heating the matrix material with an electrical arc, and heating the matrix material by burning acetylene in substantially pure oxygen.

16. The method of any one of claims 13 through 15, wherein providing a tool comprises providing a drill bit, the first structure of the tool comprising a bit body of the drill bit.

17. The method of claim 16, wherein providing a drill bit further comprises:
providing at least one cutting element secured to the bit body along an interface; and
providing a brazing alloy between the bit body and the at least one cutting element at the
5 interface, the brazing alloy securing the at least one cutting element to the bit body.

18. The method of claim 17, wherein applying the molten matrix material, at
least some of the sintered tungsten carbide pellets, and at least some of the cast tungsten
carbide granules to at least a portion of the outer surface of the tool comprises applying the
10 molten matrix material, at least some of the sintered tungsten carbide pellets, and at least
some of the cast tungsten carbide granules to exposed surfaces of the brazing alloy at the
interface between the bit body and the at least one cutting element.

19. The method of claim 17 or claim 18, wherein providing a drill bit further
15 comprises:
providing a pocket in an outer surface of the bit body; and
providing at least a portion of the at least one cutting element within the pocket, the
interface extending along adjacent surfaces of the bit body and the at least one
cutting element.

20. The method of any one of claims 17 through 19, wherein providing a drill
bit further comprises providing at least one recess in an outer surface of the drill bit
adjacent the at least one cutting element, and wherein applying the molten matrix material,
at least some of the sintered tungsten carbide pellets, and at least some of the cast tungsten
25 carbide granules to at least a portion of the outer surface of the tool comprises applying the
molten matrix material, at least some of the sintered tungsten carbide pellets, and at least
some of the cast tungsten carbide granules to the outer surface of the bit body within the at
least one recess.

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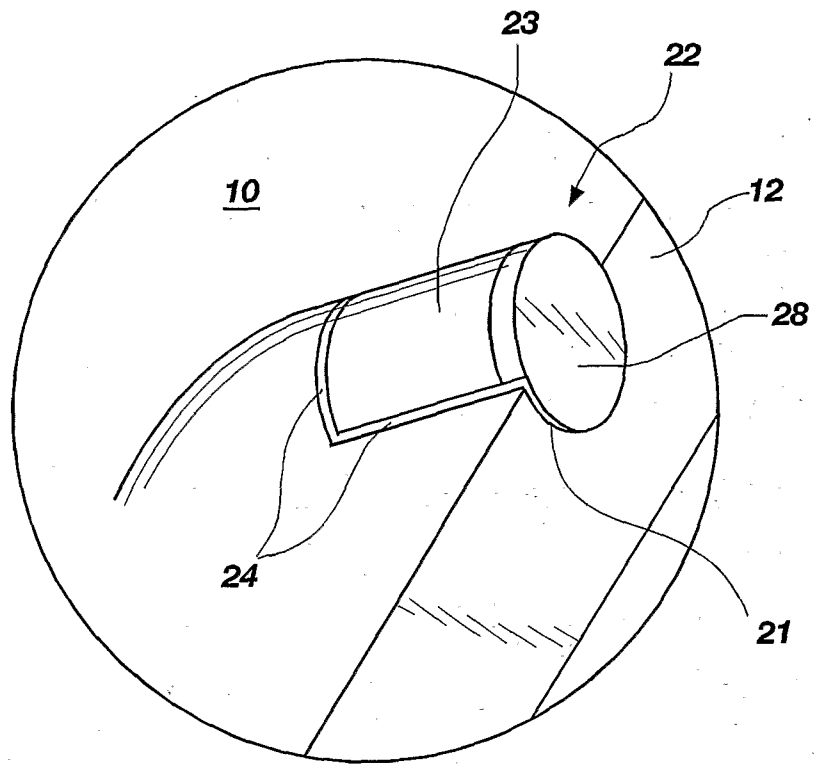


FIG. 2
(PRIOR ART)

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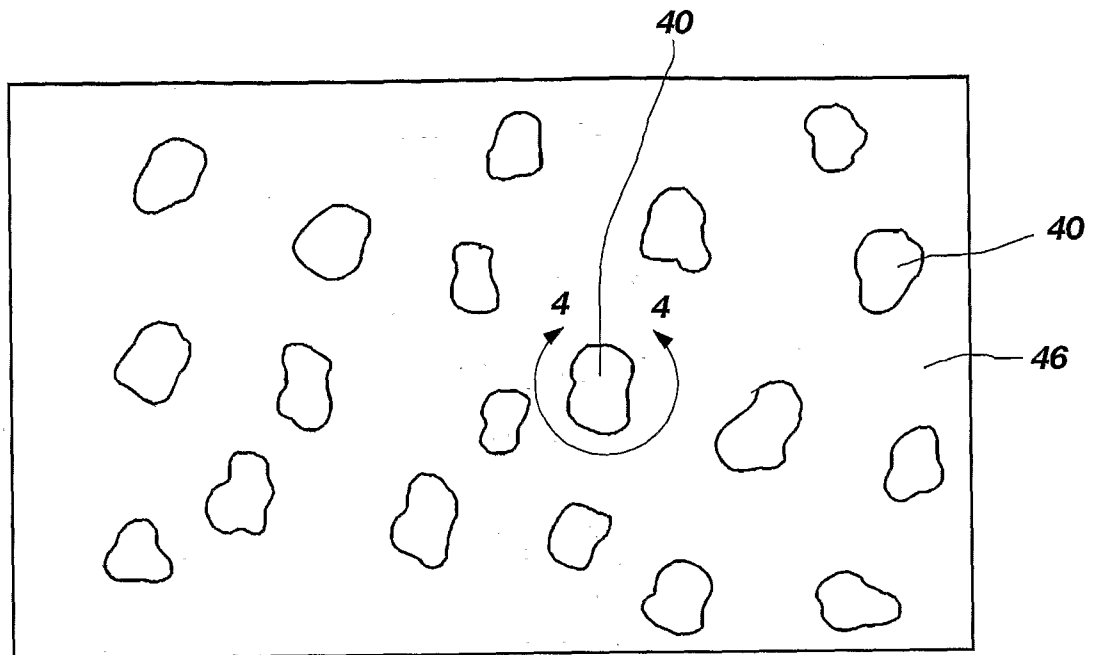


FIG. 3
(PRIOR ART)

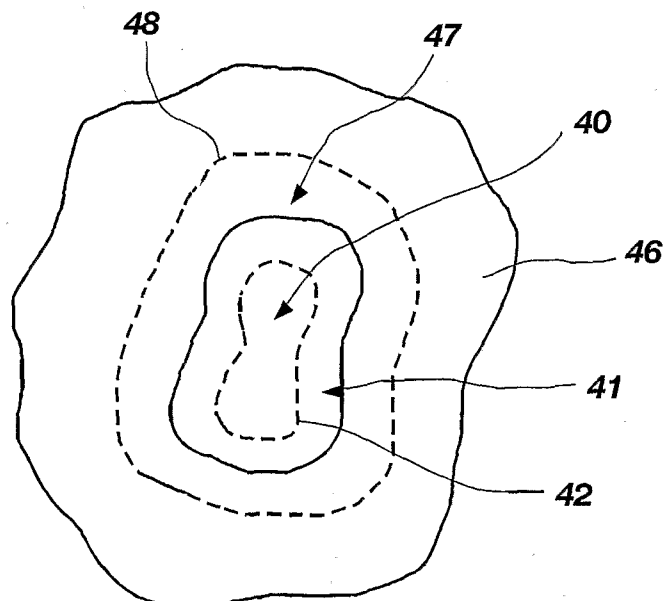


FIG. 4
(PRIOR ART)

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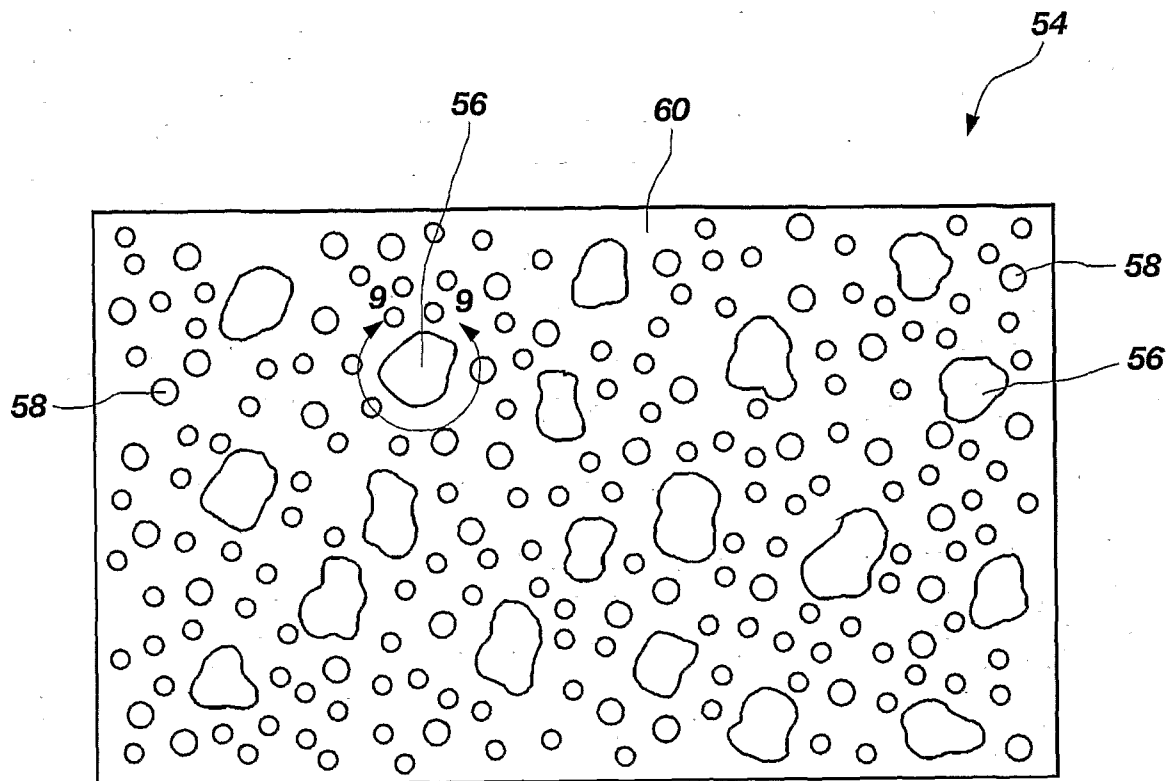


FIG. 5

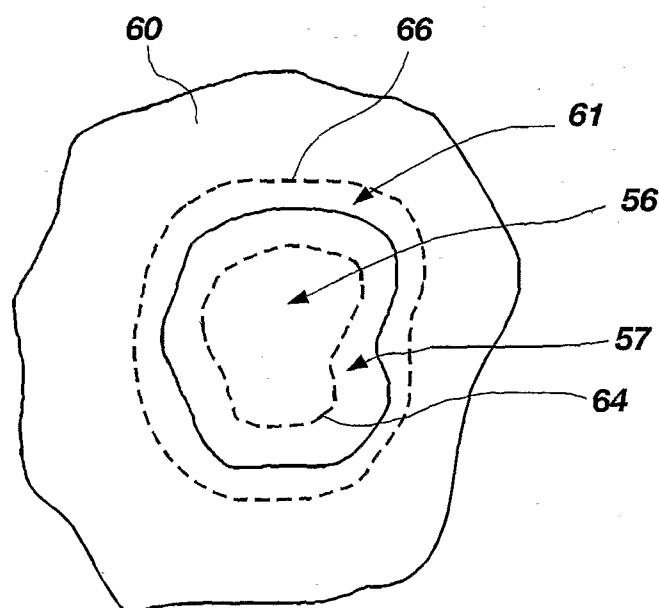


FIG. 6

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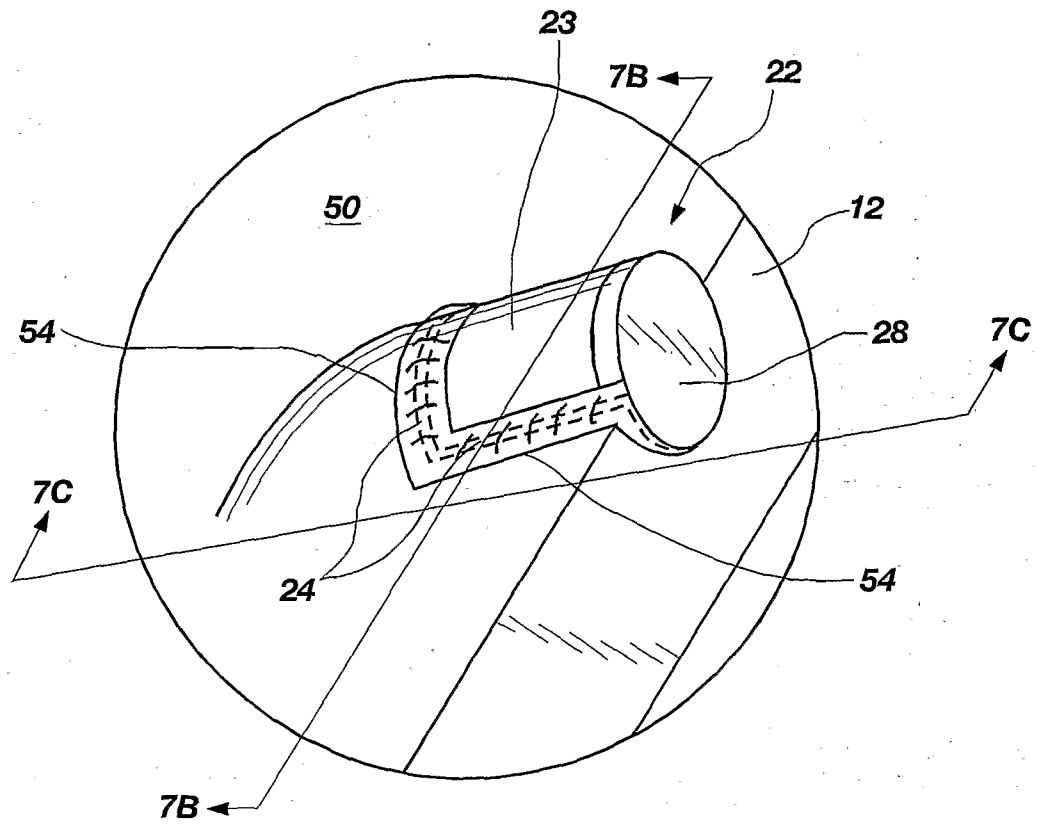


FIG. 7A

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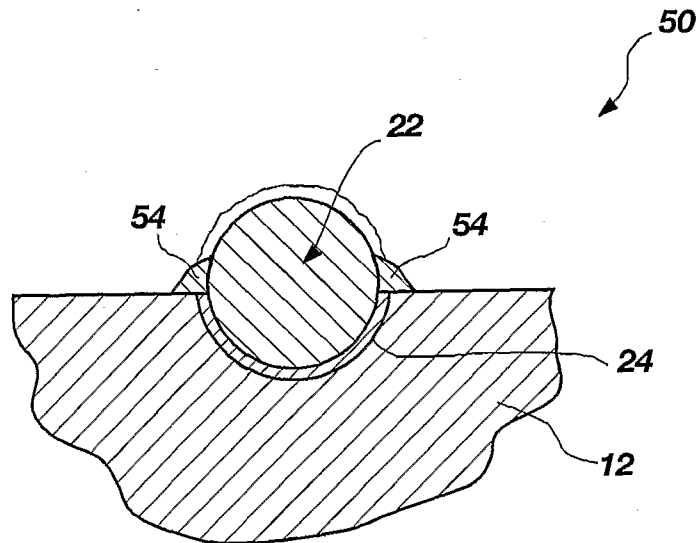


FIG. 7B

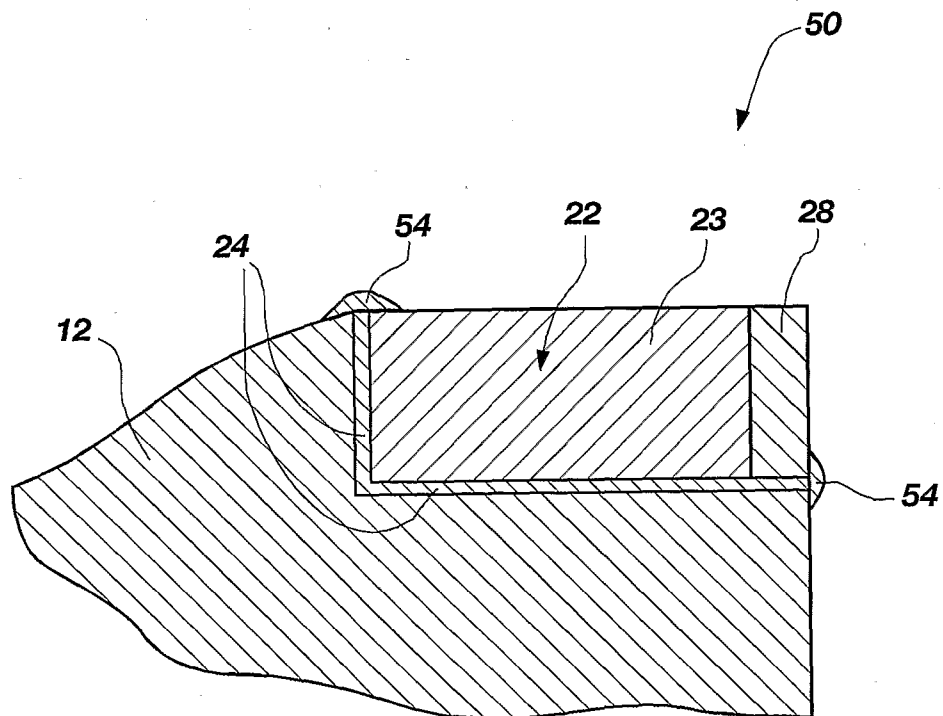


FIG. 7C

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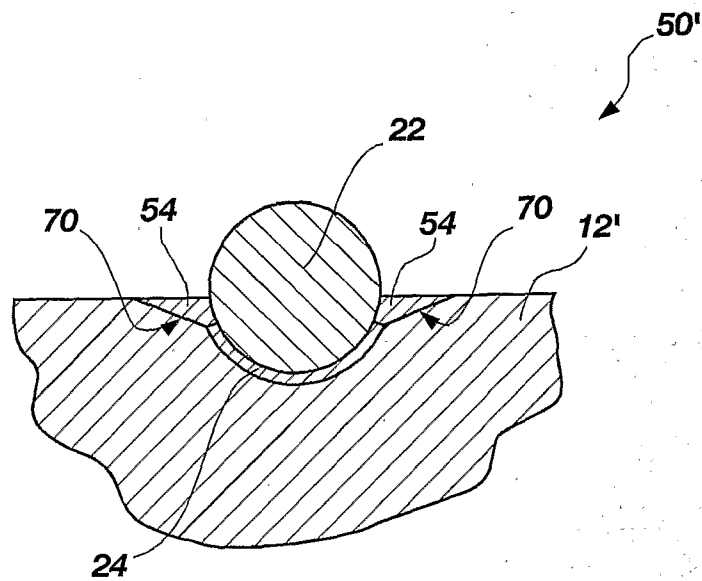


FIG. 8A

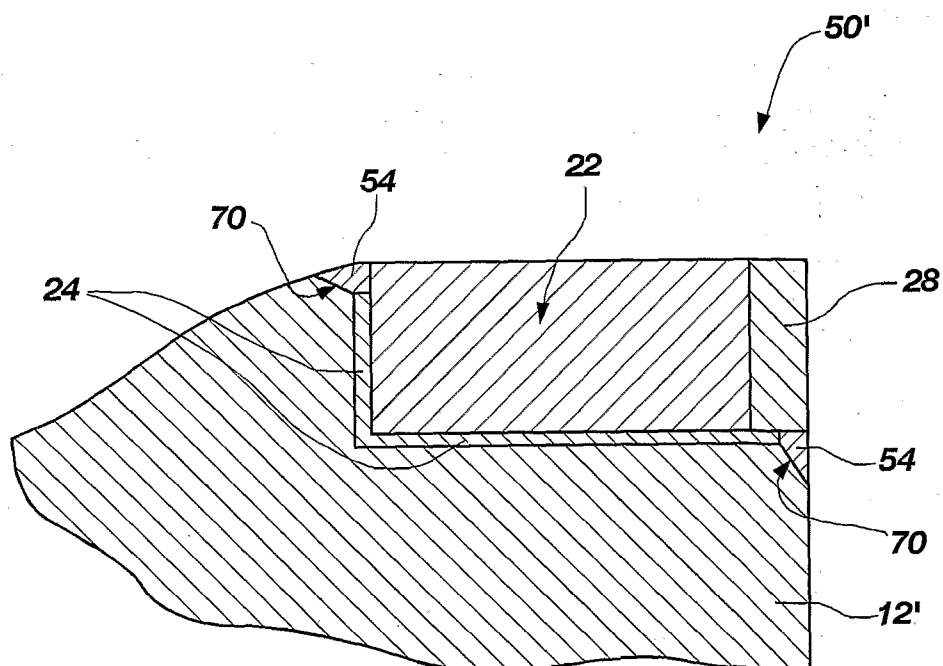


FIG. 8B

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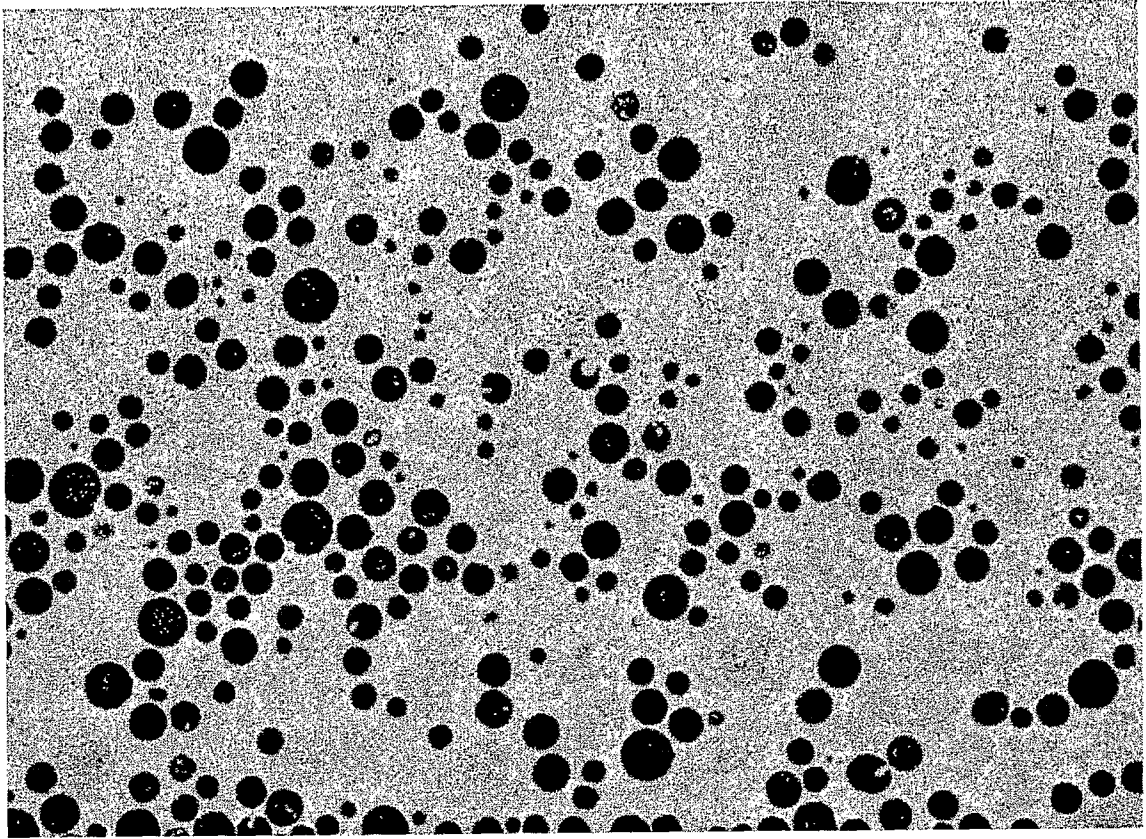


FIG. 9

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2006/035010

A. CLASSIFICATION OF SUBJECT MATTER
INV. C22C29/08

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

B23K E21B C23C C22C B22F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, CHEM ABS Data, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	GB 2 295 157 A (BAKER HUGHES INC [US]) 22 May 1996 (1996-05-22) middle page 1 - middle page 2 claims 1-14; figures 2,3	1-20
X	US 2003/079565 A1 (LIANG DAH-BEN [US] ET AL) 1 May 2003 (2003-05-01) paragraphs [0032], [0033], [0040], [0042] - [0046], [0049] claims 1-6	1-20
X	GB 2 357 788 A (BAKER HUGHES INC [US]) 4 July 2001 (2001-07-04) middle page 1-middle page 3 page 6 - page 8 figures 2,4,7	1-20
	----- -/-	



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search

18 December 2006

Date of mailing of the international search report

27/12/2006

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Authorized officer

Gavriliu, Alexandru

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2006/035010

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
E	WO 2006/099629 A (BAKER HUGHES INC [US]; OVERSTREET JAMES L [US]) 21 September 2006 (2006-09-21) entire document -----	1-20
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