

TECHNICAL DATA SHEET

PRODUCT NAME:	TA02073
PRODUCT DESIGNATION:	Fe Cr B Si Amorphous wire 1/16" Diameter
PRODUCT APPLICATION:	Cored wire for Arc Spray Systems partially amorphous
SERVICE TEMPERATURE	1700° F
COATING APPLICATIONS:	High wear, anti-skid sufacing and corrosive environments

CHEMICAL COMPOSITION (%)

Fe	Cr	B
Balance	25.0-30.0	1.5-4.0
Si	Mn	C
3.0-5.0	1.0-3.0	<1.5

TYPICAL DEPOSIT CHARACTERISTICS

HARDNESS	BOND STRENGTH	DEPOSIT RATE	WIRE COVERAGE	SURFACE FINISH
HRC 55-60	6000 psi	10 lbs./hr	1.0 oz/ft2/mil	*GRind

*Grind using Aluminum Oxide

SURFACE PREPARATION:

Surface should be clean, white metal, with no oxides (rust), dirt, grease or oil on the surface to be coated.

Note: it is best not to handle surface after cleaning.

Recommend method of preparation is to grit blast with 24 mesh aluminum oxide, rough grind or rough machine in a lathe.

RECOMMENDED SPRAY PARAMETERS:

DIAMETER	AIR PRESSURE	VOLTAGE	AMPERAGE	STANDOFF
1/16" (1.6MM)	**50-60 psi	**29-32	**100-200	4-8" (10-20 CM)

**Paramerters are typical and may vary depending on equipment used.

Contact your equipment manufacture for optimum spray parmeters.

STANDARD SIZES AND PACKAGING:

DIAMETER	PACKAGING	PART NUMBER
1/16" (1.6mm)	25# LWS	TA02073

Micrograph

