

TECHNICAL DATA SHEET

PRODUCT NAME:	TA02097
PRODUCT DESIGNATION:	Fe WC Cr Ti Ni B Si Amorphous wire 1/16" Diameter
PRODUCT APPLICATION:	Cored wire for Arc Spray Systems Ti WC in amorphous matrix
SERVICE TEMPERATURE	1000° F
COATING APPLICATIONS:	Hard, abrasive and corrosion resistan coating

CHEMICAL COMPOSITION (%)

Fe	W	Cr	Ti
Balance	21.5-24.5	12.5-14.5	5-6.5
Si	B	C	
2 max	2 max.	2 max.	

TYPICAL DEPOSIT CHARACTERISTICS

HARDNESS	BOND STRENGTH	DEPOSIT RATE	WIRE COVERAGE	SURFACE TEXTURE
HRC 65	5000 psi	10 lbs./hr/100A	1.0 oz/ft2/mil	Variable
DEPOSIT EFFICIENCY			MACHINEABILITY	
70%			NO	

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)

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

Contact your equipment manufacture for optimum spray parameters.

STANDARD SIZES AND PACKAGING:

DIAMETER	PACKAGING	PART NUMBER
1/16" (1.6mm)	25# LWS	TA02097

Micrograph

