



TECHNICAL DATA SHEET

PRODUCT NAME:	TA02024C
PRODUCT DESIGNATION:	Fe Cr Al wire 1/16" Diameter
PRODUCT APPLICATION:	Cored wire for Arc Spray Systems
COATING APPLICATIONS:	Excellent wear and high temperature oxidation resistance. Used for dimensional restoration applications.

CHEMICAL COMPOSITION (%)

Fe	Cr	Al	Mn	Si
Balance	23-24	5-5.5	0.40-0.50	1.0

TYPICAL DEPOSIT CHARACTERISTICS

HARDNESS	BOND STRENGTH	DEPOSIT RATE	WIRE COVERAGE	SURFACE TEXTURE
HRB 85-90	7000 psi	10 lbs./hr/100A	0.8 oz/ft ² /mil	Variable
DEPOSIT EFFICIENCY		MACHINEABILITY		
70%		good		

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	*28-30	*100-200	4-6" (10-15 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)	30 # LWS	TA02024C