

**TECHNICAL DATA SHEET**

<b>PRODUCT NAME:</b>	TA02075
<b>PRODUCT DESIGNATION:</b>	Ni-5%Al wire 1/16" Diameter
<b>PRODUCT APPLICATION:</b>	Solid Core Wire for Arc Spray Systems
<b>COATING APPLICATIONS:</b>	High bond strength up to 10,000 PSI Good resistance to abrasion and impact.

**CHEMICAL COMPOSITION (%)**

Ni	Al	Others
Balance	4.0-5.5	1.7 Max.

**TYPICAL DEPOSIT CHARACTERISTICS**

HARDNESS	BOND STRENGTH	DEPOSIT RATE	WIRE COVERAGE	SURFACE TEXTURE
HRB 75	10,000 psi	10 lbs./hr/100A	0.9 oz/ft <sup>2</sup> /mil	Variable
<b>DEPOSIT EFFICIENCY</b>		<b>MACHINEABILITY</b>		<b>Co-efficient of Thermal Exp.</b>
70%		good		7x10 <sup>-6</sup> in/in °F

**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	*29-30	*100-200	3-6" (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	TA02075