

## P♦MET 818 Arc Spray Wire

### DESCRIPTION

**P♦Met 818** is a solid wire specifically designed for arc spray systems. It produces a self-bonding nickel-chromium-molybdenum deposit with excellent high temperature oxidation and corrosion resistance. **P♦Met 818** can be used for dimensional restoration of parts.

### TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness                      HRC 30
- Bond Strength                            9000 psi
- Deposit Rate                              10 lbs /hr/100A
- Deposit Efficiency                        70%
- Wire Coverage                            0.8 oz/ft<sup>2</sup> / m
- Surface Texture                          \*Variable
- Machineability                            Good

\* Depends on air pressure used.

### 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 surfaces after cleaning. Recommended method of preparation is, to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.

### APPLICATION:

- Part Restoration

### SPECIFICATION:

Inconel 718

Manual 70-49-45 (ref: GE B50TF202 CL E).

### NOMINAL CHEMICAL COMPOSITION (wt%):

Cr	Fe	Mo	Cb+T a	Ti	Co	Al	Ni
19.0	17.0	3.0	5.1	1.0	1.0	0.60	Bal

### RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*29 - 32	*100 -150	*4 – 6 in (10-15cm)

\* Parameters are typical and may vary depending on equipment used. Contact your equipment manufacture for optimum spray parameters.

### STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16 (1.6mm)	25# LLWS	818062LWS01

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