

## **P♦MET 876** Arc Spray Wire

### DESCRIPTION

**P♦Met 876** is a high purity nickel-chrome-molybdenum-4 wire specifically designed for arc spraying. It produces dense, well-bonded coatings with good resistance to corrosion, and stress cracking in caustic mediums. **P♦Met 876** exhibits good abrasion and metal to metal wear resistance.

### TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness                      HRC 35
- Bond Strength                            7000 psi
- Deposit Rate                              11 lbs /hr/100A
- Deposit Efficiency                        70%
- Wire Coverage                            0.9 oz/ft<sup>2</sup> / m
- Surface Texture                          \*Variable
- 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:

- Metal to Metal
- Wear
- Digesters Corrosion
- Oxidation and Heat resistant Coatings

### SPECIFICATION:

C276

### NOMINAL CHEMICAL COMPOSITION (wt%):

Mo	Cr	Fe	W	Co	Ni
17	15	5.5	3.5	*2.5	Bal

\*Maximum

### RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*30 - 32	*100 - 300	*4 - 5 in (10 - 13cm)

\* 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	876062LWS01

The properties listed are typical and not to be construed as guaranteed values. Actual properties may vary depending on customer operating conditions. Polymet makes no warranties, express or implied, including, but not limited to, the implied warranties of merchantability and fitness for a particular purpose, except as expressly stated in Polymet's terms and conditions.