DATA SHEET
MARCH 2007
TIBH-273

P♦MET 273 Fe Cr B Si Amorphous Alloy

Arc Spray Wire

DESCRIPTION:

P♦Met 273 is a cored wire specifically designed for arc spray systems. It produces a partially amorphous, hard, abrasive and corrosion resistant coating, with a service environment up to 1700° F. High chrome like finishes can be obtained by typical grinding and lapping techniques. **P♦Met 273** is used in a wide variety of high wear applications, anti-skid surfacing applications and corrosive environments.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness HRC 55-60
- Bond Strength 6000 psi
- Deposit Rate 10 lbs/hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.6 oz/sq.ft/mil
- Surface Finish Grind**

**Grind using aluminum Oxide

APPLICATIONS:

- Boiler Tubes & Tube Shields
- Yankee Dryer Rolls
- Anti-Skid
- Fan Blades
- Drill Collars

SURFACE PREPARATION:

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated.
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.

NOMINAL CHEMICAL COMPOSISTION (wt%):

Cr	B	Mn	Si	Fe
27.5	3.7	1.7	1.6	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	50 - 60 psi	29-32	100 - 200	4 – 8 in (10 - 20cm)

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

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16 (1.6mm)	25# LLWS	273062LWS01

10073 Commerce Park Drive, Cincinnati, OH 45246 / Phone: 513-874-3586 / Fax: 513-8742880
E-Mail: sales@polymet.us