

P♦MET 296 Arc Spray Wire

DESCRIPTION:

P♦Met 296 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 of up to 1700° F. High chrome like finishes can be obtained by typical grinding and lapping techniques. **P♦Met 296** has found use in a wide variety of high wear applications, anti-skid surfacing applications, and corrosive environments. The addition of 6.2% nickel gives it greater corrosion resistance than P♦Met 272 for most environments.

TYPICAL DEPOSIT CHARACTERISTICS:

- Abrasion Resistance Good
- Typical Hardness HRC 50-55
- Bond Strength 6000 psi
- Deposit Rate 10 lbs /hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.6 oz/ft² / m
- Surface Texture *Variable
- Machineability **Grind

* Depends on air pressure used.

**Grind using aluminum Oxide

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:

- Boiler Tubes & Tube Shields
- Fan Blades
- Drill Collars

SPECIFICATION:

FeCrNiMoBCuSi

NOMINAL CHEMICAL COMPOSITION (wt%):

Cr	Ni	Mo	B	Si	Cu	Mn	Fe
23.0	6.0	3.5	2.5	2.0	2.0	1.0	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 manufacture for optimum spray parameters.

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16 (1.6mm)	25# LLWS	296062LWS01

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