



P♦MET 540 Zinc
Thermal Spray Wire

DESCRIPTION

P♦Met 540 is a 99.99% pure zinc wire specifically designed for spraying in arc spray and flame spray systems. It produces a dense, well bonded coating that is ideal for corrosion protection of steel, electrical conductivity applications and moldmaking. It is also used as a bond coat when spraying metals onto non-metallic substrates.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness 70 Rb
- Bond Strength 1200 psi
- Deposit Rate 24 lbs /hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.9oz/sq.ft/mil
- Surface Texture *Variable
- Machineability Good

* Depends on air pressure.

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.

APPLICATIONS:

- Corrosion protection of steel
- Capacitors
- Moldmaking

NOMINAL CHEMICAL COMPOSITION (wt%):

Zn
99.99%

RECOMMENDED ARC SPRAY PARAMETERS:

Air Pressure	Voltage	Amperage	Standoff
*50 - 70 psi	*21 - 23	*100 - 350	*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:

Diameters	Packaging	Part Number
0.062 (1.6 mm)	25# Spools, 500# Drums	540062LWS01, 540062DRUM01
0.079 (2.0 mm)	25# Spools, 500# Drums	540079LWS01, 540079DRUM01
0.125 (3.2 mm)	50# Coils, 500# Drums	540125COIL00, 540125DRUM01

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