

P♦MET 542 Arc Spray Wire

DESCRIPTION

P♦Met 542 is a high tin, lead free Babbitt wire specifically designed for spraying in arc spray and flame spray systems. It produces dense, well-bonded coatings particularly applicable to high speed and heavy duty bearings.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness Nil
- Bond Strength 3000 psi
- Deposit Rate 48 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.

APPLICATION:

- Bearing Surfaces

SPECIFICATION:

Babbitt

NOMINAL CHEMICAL COMPOSITION (wt%):

Sb	Cu	Sn
7.0	3.0	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*21 - 23	*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	542062LWS01

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