

P♦MET 806 Arc Spray Wire

DESCRIPTION

P♦Met 806 is a high purity nickel wire specifically designed for arc spraying. **P♦Met 806** produces dense, well-bonded coatings with excellent machineability, electrical conductivity and corrosion resistance. It is widely used for machine element repair applications requiring high corrosion resistance.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness HRB 50-60
- Bond Strength 5000 psi
- Deposit Rate 10 lbs /hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.8 oz/ft² / m
- Surface Texture *Variable
- Machineability Good

* 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:

- Resurface:
 - Pump Plungers
 - Pump Sleeves
 - Shafts
 - Impellers
 - castings

SPECIFICATION:

99% Nickel Alloy

NOMINAL CHEMICAL COMPOSITION (wt%):

Ni
99.0

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*28 - 30	*100 - 200	*4 - 7 in (10 - 17cm)

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

STANDARD SIZES & PACKAGING:

Diameter 1/16 (1.6mm)	Packaging 25# LLWS	Part Number 806062LWS01
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