

P♦MET 821
 Arc Spray Wire

DESCRIPTION

. P♦Met 821 is a high purity nickel chrome wire specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent machineability, electrical conductivity and high temperature oxidation resistance up to 1800 degrees F (980 degrees C). It is widely used for machine element repair, electrical and high temperature corrosion applications.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness HRB 90
- Bond Strength 7300 psi
- Deposit Rate 11 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:

- Oxidation and Heat resistant Coatings

SPECIFICATION:

Ni 20Cr

NOMINAL CHEMICAL COMPOSITION (wt%):

| | |
|-----------|-----------|
| Cr | Ni |
| 20 | Bal |

RECOMMENDED SPRAY PARAMETERS:

| Diameter | Air Pressure | Voltage | Amperage | Standoff |
|---------------|--------------|----------|------------|-----------------------|
| 1/16" (1.6mm) | *50 - 60 psi | *28 - 30 | *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 | 821062LWS01 |

The properties listed are typical and not to be construed as guaranteed values. Actual properties may vary depending on customer operating conditions. Polymet makes no warranties, express or implied, including, but not limited to, the implied warranties of merchantability and fitness for a particular purpose, except as expressly stated in Polymet's terms and conditions.