

**P♦MET 860**  
Arc Spray Wire

**DESCRIPTION**

**P♦Met 860** is a high purity nickel-chrome-moly wire specifically designed for arc spraying. It produces dense, well-bonded coatings with good resistance to corrosion, and stress cracking in caustic mediums.

**TYPICAL DEPOSIT CHARACTERISTICS:**

- Typical Hardness                      HRB 92
- Bond Strength                            7000 psi
- Deposit Rate                              11 lbs /hr/100A
- Deposit Efficiency                        70%
- Wire Coverage                            0.8 oz/ft<sup>2</sup> / m
- Surface Texture                          \*Variable

\* 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
- Corrosion Resistance
- Digesters

**SPECIFICATION:**

Alloy 625

**NOMINAL CHEMICAL COMPOSITION (wt%):**

Ni	Cr	Mo	Fe	Cb+T a
62.5	22	10.0	2.0	3.5

**RECOMMENDED SPRAY PARAMETERS:**

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*29 - 32	*50 - 300	*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	860062LWS01

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