

P♦MET 884 Arc Spray Wire

DESCRIPTION

P♦Met 884 is a cored wire specifically designed for both, arc spraying and flame spraying. It is self-bonding to most materials and requires minimal surface preparation. Bond strengths in excess of 9000 psi can be achieved on grit blasted surfaces. **P♦Met 884** exhibits good resistance to high temperature oxidation and abrasion, and excellent resistance to impact and bending. **P♦Met 884** can be machined and ground to a finish of 5 micro inches. **P♦Met 884** is widely used as a bond coat for subsequent thermal spray topcoats and as a one step build up material for dimensional restoration of aircraft engines.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness HRB 60-75
- Bond Strength 9100 psi
- Deposit Rate 10 lbs /hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.9 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:

- Bond Coat
- Dimensional Restoration

SPECIFICATION:

80Ni 20Al

NOMINAL CHEMICAL COMPOSITION (wt%):

Al	Ni
20	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*29 - 32	*100 - 200	*3 - 6 in (8 - 15cm)

* 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	884062LWS01

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.