

P♦MET 886
Arc Spray Wire

DESCRIPTION

P♦Met 886 is a cored wire specifically designed for arc spray systems. It produces a self-bonding nickel-chromium-aluminum deposit with excellent high temperature oxidation and corrosion resistance. **P♦Met 886** can be used for dimensional restoration of parts and is widely used in the aircraft engine repair market. The coating can be used as an undercoat for ceramics.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness HRB 85-95
- Bond Strength 9500 psi
- Deposit Rate 10 lbs /hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.8 oz/ft² / m
- Surface Texture *Variable
- Machineability Good

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.

* Depends on air pressure used.

SPECIFICATION:

APPLICATION:

- Bond Coat
- Dimensional Restoration

Ni 20Cr 7Al
PWA 36947D for PWA 271-47 Rev H, GEAE C07-043 for GE SPM 70-49-39, B50TF119-S11/CL D, CFMI CP6037 for 70-48-15, Honeywell FP5045, Type XVIII, Nickel Chromium Aluminum

SURFACE PREPARATION:

NOMINAL CHEMICAL COMPOSITION (wt%):

Cr	Al	Ni
20	7.0	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*29 - 32	*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	886062LWS01

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.