

## P♦MET 877 Monel

### Thermal Spray Wire

#### DESCRIPTION

**P♦Met 877** is specifically designed for spraying in arc spray and flame spray systems. It produces well-bonded coatings with excellent Machineability. **P♦Met 877** has good corrosion resistance, especially in seawater and caustic environments.

#### TYPICAL DEPOSIT CHARACTERISTICS:

• Corrosion Resistance	Good
• Typical Hardness	HRB 84
• Bond Strength	4310 psi
• Deposit Rate	10 lbs /hr/100A
• Deposit Efficiency	70%
• Wire Coverage	0.9 oz/ft <sup>2</sup> / 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.

#### APPLICATIONS:

- Machine Element Restoration
- Sea Water Immersion
- Propellers
- Steam Valve Components
- Printing Rolls

#### SPECIFICATION:

Monel 400

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

<b>Ni</b>	<b>Cu</b>	<b>Mn</b>	<b>Fe</b>
65.0	31.0	1.2	1.7

#### 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)
1/8" (3.2mm)	-----	-----	-----	-----

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

#### STANDARD SIZES & PACKAGING:

<b>Diameter</b>	<b>Packaging</b>	<b>Part Number</b>
1/16 (1.6mm)	25# LLWS	59062LWS01
1/8" (3.2mm)	50# Coil	590125COIL00

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.