



**P♦MET 540 Zinc**  
Thermal Spray Wire

**DESCRIPTION**

**P♦Met 540** is a 99.99% pure zinc wire specifically designed for spraying in arc spray and flame spray systems. It produces a dense, well bonded coating that is ideal for corrosion protection of steel, electrical conductivity applications and moldmaking. It is also used as a bond coat when spraying metals onto non-metallic substrates.

**TYPICAL DEPOSIT CHARACTERISTICS:**

- Typical Hardness 70 Rb
- Bond Strength 1200 psi
- Deposit Rate 24 lbs /hr/100A
- Deposit Efficiency 70%
- Wire Coverage 0.9oz/sq.ft/mil
- Surface Texture \*Variable
- Machineability Good

\* Depends on air pressure.

**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:**

- Corrosion protection of steel
- Capacitors
- Moldmaking

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

**Zn**  
99.99%

**RECOMMENDED ARC SPRAY PARAMETERS:**

Air Pressure	Voltage	Amperage	Standoff
*50 - 70 psi	*21 - 23	*100 - 350	*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:**

Diameters	Packaging	Part Number
0.062 (1.6 mm)	25# Spools, 500# Drums	540062LWS01, 540062DRUM01
0.079 (2.0 mm)	25# Spools, 500# Drums	540079LWS01, 540079DRUM01
0.125 (3.2 mm)	50# Coils, 500# Drums	540125COIL00, 540125DRUM01

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.