DATA SHEET
March 2007
TIBA-001

P♦MET 709

Arc Spray Wire

DESCRIPTION

P♦Met 709 is a carbon steel wire, copper coated and specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent wear resistance, and is widely used for machine element repair, dimensional restoration and wear resistant applications. **P♦Met 709** low shrink characteristics allow for increased coating thickness.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness — HRB 95-100
- Bond Strength — 5800 psi
- Deposit Rate — 10 lbs /hr/100A
- Deposit Efficiency — 80%
- Wire Coverage — 0.8 oz/ft^2 / 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:

- Part Restoration
- Seating Surfaces
- Press Fit Surfaces

SPECIFICATION:

Carbon Steel Wire

NOMINAL CHEMICAL COMPOSISTION (wt%):

Mn	Si	C	Fe
0.8	0.2	0.15	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16” (1.6mm)	*50 - 60 psi	*28 - 30	*100 - 300	*4 – 7 in (10 - 17cm)

* 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	709062LWS01

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