

P♦MET 710 Arc Spray Wire

DESCRIPTION

P♦Met 710 is a 304 stainless steel wire specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent machineability and wear and corrosion resistance. **P♦Met 710** is widely used for machine element repair, dimensional restoration and wear resistance applications. It has relatively high shrink characteristics and should not be used for coatings over 0.075 inches thick.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness HRB 95-100
- Bond Strength 4650 psi
- Deposit Rate 10 lbs /hr/100A
- Deposit Efficiency 75%
- Wire Coverage 0.8 oz/ft² / mil
- 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
- Resurface;
 - Paper Mill Cylinders
 - Rams
 - Shafts
 - Pump Plungers

SPECIFICATION:

304 SS

NOMINAL CHEMICAL COMPOSITION (wt%):

Cr	Ni	Mn	Si	Fe
19.0	9.3	2.0	1.0	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50 - 60 psi	*28 - 30	*100 - 200	*4 - 6 in (10 - 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	710062LWS01

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.