**DATA SHEET**
March 2007
TIBA-004

# P♦MET 720

**Arc Spray Wire**

## DESCRIPTION

**P♦Met 720** is a 420 stainless steel wire, specifically designed for arc spray processes. **P♦Met 720** forms a dense, well bonded coating, with excellent wear resistance and good corrosion resistance. It is widely used for machine elements repair, dimensional restoration, and wear resistant application. **P♦Met 720's** low shrink rate characteristics, allows for increased coating thickness on parts requiring heavier coatings.

## TYPICAL DEPOSIT CHARACTERISTICS:

- Abrasion Resistance — Excellent
- Corrosion Resistance — Good
- Typical Hardness — HRC 40-45
- Bond Strength — 6500 psi
- Deposit Rate — 10 lbs /hr/100A
- Deposit Efficiency — 70%
- Wire Coverage — 0.8oz/sq.ft/mil
- Coating Shrink Rate — Low

## 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:

- Paper Roll
- Parts Restoration
- Corrosion / Wear

## SPECIFICATION:

420 SS

## NOMINAL CHEMICAL COMPOSISTION (wt%):

| Cr | Si | Mn | C | Fe |
|---|---|---|---|---|
| 13.0 | 1.0 | 1.0 | 0.3 | 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) |

## STANDARD SIZES & PACKAGING:

| Diameter | Packaging | Part Number |
|---|---|---|
| 1/16" (1.6mm) | 25# Spool | |



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