

Vecalloy B Amorphous Alloy

Arc Spray Wire

DESCRIPTION:

Vecalloy B is a cored wire specifically designed for arc spray systems. It produces an amorphous, hard, abrasive and corrosion resistant coating, with a service environment up to 1700° F. The inclusion of 2.0% aluminum in the formulation results in extremely high bond strength and particle to particle adhesion. High chrome like finishes can be obtained by typical grinding and lapping techniques. Vecalloy B can be used in a wide variety of high wear applications, anti-skid surfacing applications and corrosive environments.

TYPICAL DEPOSIT CHARACTERISTICS:

- Typical Hardness: 9850 Vickers
67 HRC (converted)
- Bond Strength: 10,000 psi
- Deposit Rate: 10 lbs/hr/100A
- Deposit Efficiency: 80%
- Wire Coverage: 0.8 oz/sq.ft/mil
- Surface Finish: Grind**
- Corrosion Resistance: Excellent

SURFACE PREPARATION:

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. It is best not to handle surfaces after cleaning. Recommended method of preparation is to grit blast with 18-24 mesh aluminum oxide.

**Grind using aluminum Oxide

APPLICATIONS:

- Boiler Tubes & Tube Shields
- Yankee Dryer Rolls
- Anti-Skid
- Fan Blades
- Drill Collars

CHEMICAL COMPOSITION (%):

Cr	Nb	B	Ni	Si	Mn	Al	Fe
13.2	6.0	4.2	5.5	1.2	1.3	2.0	Balance

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	50 - 60 psi	29-32	150 - 250	4 – 8 in (10 - 20cm)

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

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16 (1.6mm)	25# LLWS	VECB062LWS00

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