

SP 1.3505

CATEGORY	Metal spray wires
TYPE	Solid thermal spray wire for coatings with high hardness.
APPLICATIONS	Machine parts, storage surfaces, shafts etc..
PROPERTIES	High-alloyed solid wire for metal spray on a C-Cr carbide basis for hard deposits on parts subject to abrasion. Excellent bonding strength.
CLASSIFICATION	EN ISO 14919:~150 Cr 4 DIN: W.Nr. 1.3505

SUITABLE FOR Flame spray, electric spray and high speed flame spray.

SPRAY WIRE ANALYSIS (TYPICAL VALUES)

C	Mn	Si	Cr
1,00	0,30	0,25	1,50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
							47-52

SPRAY PARAMETERS / PACKING

Parameters					Packing
D (mm)	Voltage (V)	Current (A)	Distance	Air pressure	kg / 1000
1,6	32	100-200	15-22 cm	60 psi	15 kg K-300 / H-420 20 kg
2,4					
3,2					
4,76					

REDRYING TEMPERATURE not required

PREPARATION The surface must be free from dirt, grit blasting in a 90 degrees angle with aluminum oxide usually offers the best results.