

CATEGORY	Metal spray wires	
TYPE	Copper coated solid thermal spray wire for coatings with high hardness.	
APPLICATIONS	Machine parts, storage surfaces, shafts, cylinder surfaces etc..	
PROPERTIES	Extremely hard, wear resistant high carbon alloy with excellent lubricating and sliding properties even at elevated temperatures.	
CLASSIFICATION	EN ISO W.Nr.	14919: 5.3 1.0616
SUITABLE FOR	Flame spray, electric spray and high speed flame spray.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Mn	C
0.25	0.6	0.8

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 55

WELDING PARAMETERS / PACKING

PARAMETERS	PARAMETERS	PARAMETERS	PARAMETERS	PARAMETERS	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	DISTANCE	AIR PRESSURE	KG / SPOOL / DRUM
1,6	32	100-200	15-22 CM	60 PSI	15 KG K-300 / H-420 20 KG / 250 KG

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	None