

CATEGORY	Metal spray wires	
TYPE	Nickel based spray wire with excellent bonding properties	
APPLICATIONS	Bonding layers in case high bonding strength is required, recommended as bonding layer for ceramic coatings.	
PROPERTIES	Exothermic reaction for exceptionally high bond strength Resists corrosion and alkaline environments Excellent bond coat Service up to 800 °C (1470 °F) Is an ERNi-1 type specially modified for spraying.	
CLASSIFICATION	EN ISO W.Nr.	14919: not classified 2.4156
SUITABLE FOR	Impellers, machine parts in chemical plants, bond coating for use with ceramic coatings, shafts, high temperature applications.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Ni	Ti	Fe	Al
0.08	0.2	96	3	0.5	1

WELDING PARAMETERS / PACKING

SPRAY PARAMETERS	SPRAY PARAMETERS	SPRAY PARAMETERS	PACKING
D (MM)	VOLTAGE (V) (DC+)	CURRENT (A)	KG / SPOOL
1.6	27-30	100-250	15

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175