Technical data sheet 011121MBA	Cored thermal spray wire # HARDSPRAY 140-TS	Welding Alloys

CLASSIFICATION

EN ISO 14919: NA

DESCRIPTION

- Metal cored wire specifically designed for thermal spray with the twin wire arc process
- Produces a hard deposit exhibiting high resistance to erosion and corrosion
- Excellent bonding properties
- Highly compact deposit
- Low coefficient of friction
- High percentage of complex amorphous phases
- High deposition rate

APPLICATIONS

HARDSPRAY 140-TS is mainly used for arc spraying of parts subject to erosion at high temperature (up to 900°C), in gaseous environment.

Examples:
Fans, tubes and water walls of boilers, cyclones, steam turbines casings etc.

CHEMICAL COMPOSITION OF DEPOSIT

C	Mn	Si	Cr	W	Nb	Mo	B	Fe
1.15	1.0	1.0	19	5.3	6.3	3	4.7	Bal.

TYPICAL PHYSICAL AND MECHANICAL PROPERTIES

As-sprayed hardness: 850 – 1200 $Hv_{0.5}$
Melting point: 1200°C
Bond strength: 40 MPa @ 20 mils
Coating density: 6.7 g/cm^3

TYPICAL SPRAYING PARAMETERS (1.6 mm wire)

Arc load voltage: 29 - 32V
Current intensity: 100 - 200A
Standoff distance: 75-100mm
Air Pressure Range 50-75 PSI
Other parameters according to equipment.
Spraying rate: 3.5-4.0 kg/hour

PACKAGING

Diameter	1.6 mm
Spool type	BS300
Weight	15 kg

Other packaging: please consult us