


<b>Technical data sheet</b>  EN130524GB	Thermal spraying cored wire <b>HARDSPRAY 140-TS</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

EN ISO 14919: 5 - 1.6 - 4

### DESCRIPTION

- Metal cored wire specifically designed for thermal spraying by using arc wire spray process
- Amorphous alloy with fine particles
- Produces a hard coating exhibiting high resistance to abrasion and corrosion, thermal resistant
- High resistance to metal-to-metal friction
- Easy to polish to obtain a high chrome like finishing after grinding
- Excellent bonding properties
- Highly compact deposit
- High deposition rate

### APPLICATIONS

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

#### Examples:

Pressure and conveyor screws, grinding areas, fans, casing, cyclones, etc.

### CHEMICAL COMPOSITION OF DEPOSIT

C	Cr	Mo	Nb	W	B	Fe
1.2	22.0	4.0	3.5	6.5	4.5	Bal.

### TYPICAL PHYSICAL AND MECHANICAL PROPERTIES

As-sprayed hardness: 820 - 1050 HV / (65 - 70 HRC)  
Melting point: 1430 °C  
Bond strength: 40 MPa @ 20 mils  
Coating density: 6.7 g/cm<sup>3</sup>

### TYPICAL ARC WIRE SPRAY PARAMETERS (1.6 mm wire)

Arc load voltage: 31 V  
Current intensity: 150 A  
Standoff distance: 100 mm  
Air pressure: 3.5 bar  
Spraying rate: 3.5 kg/hour  
Other parameters according to equipment.

### STANDARD DIAMETERS (mm)

Diameters: 1.6 - 2.0 - 2.4 - 2.8 - 3.2 mm  
Other diameters: please consult us

### PACKAGING

Diameter	1.6 - 2.4 mm	2.4 - 3.2 mm
Spool type	BS 300	B 450
Weight	15 kg	25 kg

Other packaging: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.