

**Technical  
data sheet**

EN170823GB

Cored thermal spraying wire

**HARDSPRAY K600-TS****CLASSIFICATION**

EN ISO 14919: NA

**DESCRIPTION**

- Metal cored wire specifically designed for thermal spraying by using arc wire spray process
- Copper flash for easy feeding and electrical contact.
- Machining by grinding.
- Dense deposit.
- Colour matching with mild steel.

**APPLICATIONS**

- Rebuilding of bearing or sealing surfaces.

**TYPICAL DEPOSIT ANALYSIS**

C	Mn	Si	Cr	Mo	Fe
0.50	1.20	0.70	6.00	0.70	Bal.

**TYPICAL DEPOSIT PROPERTIES**

Hardness after spraying: 450 - 500 HB (according to the arc wire spray parameters).  
Hardness after welding (for info): 60 HRC.

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

Arc load voltage: 31 V  
Current intensity: 150 A  
Standoff distance: 75 - 100 mm  
Other parameters according to equipment.

**STANDARD DIAMETERS (mm)**

Diameter: 1.6 mm  
Other diameters: please consult us

**PACKAGING**

Diameter	1.6 mm
Spool type	BS 300
Weight	15 kg

Other packaging: please consult us