Technical data sheet EN130624GB	Thermal spraying cored wire **HARDSPRAY NI Cr20-TS**	Welding Alloys

CLASSIFICATION

EN ISO 14919: 6.4 - 1.6 - 4

DESCRIPTION

- Metal cored wire specifically designed for thermal spraying by using arc wire spray process
- Ni-Cr alloy wire dedicated to bonding layer
- Outstanding corrosion resistant protective coatings in aggressive chloride environment
- Excellent bonding properties
- Highly compact deposit
- High deposition rate

APPLICATIONS

HARDSPRAY NI Cr20-TS is mainly used for thermal spraying bonding of parts subject to high corrosion at high temperature, up to 650 °C

Examples:
Waste to energy boiler tubes, gas turbines, ceramics bonding, etc

TYPICAL DEPOSIT ANALYSIS

Cr	Ni
20	Bal.

TYPICAL DEPOSIT PHYSICAL AND MECHANICAL PROPERTIES

As-sprayed hardness: 150 - 200 HV
Melting point: 1480 °C
Bond strength: 40 MPa @ 20 mils
Coating density: 7.0 g/cm^3

TYPICAL ARC WIRE SPRAY PARAMETERS (1.6 mm wire)

Arc load voltage: 28 V
Intensity: 250 A
Standoff distance: 150 mm
Air pressure: 3.5 bar
Spraying rate: 5.0 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