


Technical data sheet EN130624GB	<p style="text-align: center;">Thermal spraying solid wire</p> <h2 style="text-align: center;">WA SPRAY 13Cr-TS</h2>	 Welding Alloys
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CLASSIFICATION

EN ISO 14919: 5.7 - 1.6 - 1

DESCRIPTION

- Solid wire specifically designed for thermal spraying by using arc wire spray process
- Hard martensitic stainless steel with 13% chromium and high carbon content, type 420
- Good resistance to wear from friction, erosion, corrosion and thermal fatigue
- Easy to polish by grinding
- Excellent bonding properties
- Highly compact deposit
- High deposition rate

APPLICATIONS

HARDSPRAY 13Cr-TS is mainly used for component restoration jobs subject to wear and corrosion

Examples:

Machine elements, cylinder liners, pistons, crankshaft bearings, hydraulic rams, paper rolls, etc.

TYPICAL DEPOSIT ANALYSIS

C	Mn	Si	Cr	Fe
0.3	0.6	1.0	13.0	Bal.

TYPICAL DEPOSIT PHYSICAL AND MECHANICAL PROPERTIES

As-sprayed hardness: 350 - 450 HV / (35 - 45 HRC)
Melting point: 1450 °C
Bond strength: 40 MPa @ 20 mils
Coating density: 7.2 g/cm³

TYPICAL ARC WIRE SPRAY PARAMETERS (1.6 mm wire)

Arc load voltage: 30 V
Intensity: 150 A
Standoff distance: 100 mm
Air pressure: 3.5 bar
Spraying rate: 4.0 kg/hour
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