**PRODUCT OVERVIEW**

PMET 273 is a cored wire specifically designed for arc spray systems. It produces a partially amorphous, hard, abrasive and corrosion resistant coating, with a service environment up to 1700° F. High chrome like finishes can be obtained by typical grinding and lapping techniques. PMET 273 is used in a wide variety of high wear applications, anti-skid surfacing applications and corrosive environments.

**TYPICAL DEPOSIT CHARACTERISTICS:**

- Typical Hardness: HRC 55-60
- Bond Strength: 6000 psi
- Deposit Rate: 10 lbs/hr/100A
- Deposit Efficiency: 70%
- Wire Coverage: 1.0 oz/ft² / mil
- Surface Finish: Grind **

**SURFACE PREPARATION**

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. **Note:** It is best not to handle surfaces after cleaning. Recommended method of preparation is to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.

**APPLICATION**

- Boiler tubes & tube shields
- Yankee Dryer Rolls
- Anti-skid
- Fan blades
- Drill collars

**NOMINAL CHEMICAL COMPOSITION (wt%)**

<table>
<thead>
<tr>
<th>Cr</th>
<th>B</th>
<th>Mn</th>
<th>Si</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>29.0</td>
<td>3.7</td>
<td>1.7</td>
<td>4.6</td>
<td>Bal</td>
</tr>
</tbody>
</table>

**RECOMMENDED SPRAY PARAMETERS:**

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Air Pressure</th>
<th>Voltage</th>
<th>Amperage</th>
<th>Standoff</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16” (1.6mm)</td>
<td>*50-60 psi</td>
<td>*29-32</td>
<td>*100-200</td>
<td>4-8 in (10-20 cm)</td>
</tr>
</tbody>
</table>

* Parameters are typical and may vary depending on equipment used. Contact your equipment manufacturer for optimum spray parameters

**STANDARD SIZES & PACKAGING:**

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Packaging</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16” (1.6mm)</td>
<td>25# LWS</td>
<td>273062LWS01</td>
</tr>
</tbody>
</table>

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