

PRODUCT OVERVIEW

PMET 549 is a pure tin (99.9% minimum purity) wire specifically designed for spraying in arc spray and flame spray systems. It produces dense, well-bonded coatings particularly applicable for electrical conductivity applications

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRB 65-70
⇒ Bond Strength:	2500 psi
⇒ Deposit Rate:	48 lbs/hr/100A
⇒ Deposit Efficiency	50% (arc spray) 70% (flame spray)
⇒ Wire Coverage:	1.0oz/ft ² / mil(arc) 0.8oz/ft ² / mil(flame)
⇒ Surface Texture	* Variable
⇒ Machineability	Good

* Depends on air pressure used

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

- ⇒ Solderable surface for electrical components
- ⇒ EMI/RFI Shielding

SPECIFICATION

PMET 549 Tin

NOMINAL CHEMICAL COMPOSITION (wt%)

Sn

99.9%

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*21-23	*100-200	*4-8 in (10-20 cm)
.079" (2.0mm)	* 50-60 psi	*21-23	*100-200	*4-8 in (10-20cm)

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

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
.062" (1.6mm)	25# LWS	549062LWS00
0.78" (2.0mm)	25# LWS	549078LWS00