

PRODUCT OVERVIEW

PMET 818 is a solid wire specifically designed for arc spray systems. It produces a self-bonding nickel-chromium-molybdenum deposit with excellent high temperature oxidation and corrosion resistance. PMET 818 can be used for dimensional restoration of parts.

TYPICAL DEPOSIT CHARACTERISTICS:

- ⇒ Typical Hardness: HRC 30
- ⇒ Bond Strength: 9000 psi
- ⇒ Deposit Rate: 10 lbs/hr/100A
- ⇒ Deposit Efficiency: 70%
- ⇒ Wire Coverage: 0.8 oz/ft² / mil
- ⇒ Surface Texture: * Variable
- ⇒ Machinability: 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

- ⇒ Part Restoration

SPECIFICATION

Inconel 718

Manual 70-49-45 (ref: GE B50TF202 CL E).

NOMINAL CHEMICAL COMPOSITION (wt%)

Ni	Fe	Mo	Cb+Ta	Ti	Co	Al	Ni
99.0	17.0	3.0	5.1	1.0	1.0	0.60	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*29-32	*100-150	*4-6 in (10-15 cm)

* 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
1/16" (1.6mm)	25# LWS	818062LWS00