

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/ft ² / 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

NOMINAL CHEMICAL COMPOSITION (wt%)

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