

## PRODUCT OVERVIEW

**PMET 223** is a cored wire specifically designed for arc spray systems. It produces a hard, well bonded coating that is abrasive and corrosion resistant. PMET 223 can be easily machined with carbide tools, yielding a smooth, low coefficient of friction surface finish, suitable for a number of applications.

## TYPICAL DEPOSIT CHARACTERISTICS:

|                      |                              |
|----------------------|------------------------------|
| ⇒ Typical Hardness:  | HRC 39-42                    |
| ⇒ Bond Strength:     | 5000 psi                     |
| ⇒ Deposit Rate:      | 8 lbs/hr/100A                |
| ⇒ Deposit Efficiency | 70%                          |
| ⇒ Wire Coverage:     | 1.0 oz/ft <sup>2</sup> / mil |
| ⇒ Surface Finish     | Grind **                     |

\*\* Grind using aluminum oxide

## 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
- ⇒ Fan Blades
- ⇒ Food Processing
- ⇒ Paper Processing

## NOMINAL CHEMICAL COMPOSITION (wt%)

|           |           |          |           |           |           |           |
|-----------|-----------|----------|-----------|-----------|-----------|-----------|
| <b>Cr</b> | <b>Ni</b> | <b>C</b> | <b>Mn</b> | <b>Si</b> | <b>Mo</b> | <b>Fe</b> |
| 26.0      | 3.0       | 1.7      | 1.6       | 1.6       | 0.8       | Bal       |

## RECOMMENDED SPRAY PARAMETERS:

| Diameter      | Air Pressure | Voltage | Amperage | Standoff          |
|---------------|--------------|---------|----------|-------------------|
| 1/16" (1.6mm) | *60 psi      | *32     | *100-200 | 4-8 in (10-20 cm) |

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

## STANDARD SIZES & PACKAGING:

|                 |                  |                    |
|-----------------|------------------|--------------------|
| <b>Diameter</b> | <b>Packaging</b> | <b>Part Number</b> |
| 1/16" (1.6mm)   | 25# LWS          | 223062LWS01        |