

## PRODUCT OVERVIEW

**PMET 296** 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 of up to 1700° F. High chrome like finishes can be obtained by typical grinding and lapping techniques. PMET 296 has found use in a wide variety of high wear applications, anti-skid surfacing applications, and corrosive environments.

## TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Abrasion Resistance:	Good
⇒ Typical Hardness:	HRC 50-55
⇒ Bond Strength:	6000 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	70%
⇒ Wire Coverage:	0.6 oz/ft <sup>2</sup> / mil
⇒ Surface Texture	* Variable
⇒ Machinability	** Grind

\* Depends on air pressure used

\*\* 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
- ⇒ Drill Collars

## SPECIFICATION

FeCrNiMoBCuSi

## NOMINAL CHEMICAL COMPOSITION (wt%)

<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>B</b>	<b>Si</b>	<b>Cu</b>	<b>Mn</b>	<b>Fe</b>
23.0	6.0	3.5	2.5	2.0	2.0	1.0	Bal

## RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*29-32	*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)	30# LWS	296062LWS01