Technical Datasheet

PMET 710 / 304 Stainless

June 2024

PRODUCT OVERVIEW

PMET 710 is a 304 stainless steel wire specifically designed for arc spraying. It produces a dense, well-bonded coating with excellent machinability and wear and corrosion resistance. PMET 710 is widely used for machine element repair, dimensional restoration and wear resistance applications. It has relatively high shrink characteristics and should not be used for coatings over 0.075 inches thick.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRB 95-100
⇒ Bond Strength:	4650 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	75%
⇒ 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
⇒ Resurface
- Paper Mill Cylinders
- Rams
- Shafts
- Pump Plungers

SPECIFICATION

304 SS

NOMINAL CHEMICAL COMPOSITION (wt%)

Cr	Ni	Mn	Si	Fe
19.0	9.3	2.0	1.0	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16” (1.6mm)	*50-60 psi	*28-30	*100-200	*4-6 in (8-15 cm)

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16” (1.6mm)	22# LWS	710062LWS01

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