

PRODUCT OVERVIEW

PMET 731 is an iron chromium aluminum wire specifically designed for arc spraying. It is available as both a solid wire and a cored wire. Both produce dense, well-bonded coatings with excellent wear and high temperature oxidation resistance. It is widely used for machine element repair and dimensional restoration applications. PMET 731's low shrink characteristic alloys increased coating thickness. PMET 731 is machinable.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRB 85-90
⇒ Bond Strength:	7000 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.

APPLICATIONS

- ⇒ Boiler Tubes
- ⇒ Boiler Tube Shields
- ⇒ Dimensional Restoration

NOMINAL CHEMICAL COMPOSITION (wt%)

Fe	Cr	Al	Mn	Si
Bal	23.5	5.3	0.45	1.0

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*28-30	*100-200	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	Type
1/16" (1.6mm)	30# LWS	731062LWS00	Solid wire
1/16" (1.6mm)	25# LWS	731062LWS02	Cored wire