

PRODUCT OVERVIEW

PMET 821 is a high purity nickel chromium wire specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent machineability, electrical conductivity, and high temperature oxidation resistance up to 1800 degrees F (980 degrees C). It is widely used for machine element repair, electrical and high temperature corrosion applications.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRB 90
⇒ Bond Strength:	7300 psi
⇒ Deposit Rate:	11 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

⇒ Oxidation and heat resistant coating applications

NOMINAL CHEMICAL COMPOSITION (wt%)

Cr	Ni
20.0	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*28-30	*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:

Diameter	Packaging	Part Number
1/16" (1.6mm)	25# LWS	821062LWS00