

PRODUCT OVERVIEW

PMET 860BC is a high purity nickel-chrome-moly-boron wire specifically designed for arc spraying. It produces dense, well-bonded coatings with good resistance to corrosion, and stress cracking in caustic mediums. The addition of boron and carbon forms boron carbide in the coating, making it very hard and wear resistant. Arc spray coatings with 860BC are generally resistant to most service environments up to 625 C.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRC 65-70
⇒ Bond Strength:	10,400 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	70%
⇒ Wire Coverage:	0.8 oz/ft ² / mil
⇒ Surface Texture	*Variable

* 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

- ⇒ High temperature wear & corrosion resistant coatings
- ⇒ Waste to energy boiler tubes
- ⇒ Digesters

NOMINAL CHEMICAL COMPOSITION (wt%)

Ni	Cr	B	Mo	Si	Fe	C
BAL	31.0	4.0	3.0	2.5	2.0	2.0

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*29-32	*150-300	*4-6 in (10-15 cm)

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16" (1.6mm)	25# LWS	860BC062LWS01