

PRODUCT OVERVIEW

PMET 877 is specifically designed for spraying in arc spray and flame spray systems. It produces well-bonded coatings with excellent machineability. PMET 877 has good corrosion resistance, especially in sea water and caustic environments.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRB 84
⇒ Bond Strength:	4310 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	70%
⇒ Wire Coverage:	0.9 oz/ft ² / mil
⇒ Surface Texture	* Variable
⇒ Machinability	Good
⇒ Corrosion Resistance	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

- ⇒ Machine element restoration
- ⇒ Sea water immersion
- ⇒ Propellers
- ⇒ Steam valve components
- ⇒ Printing rolls

NOMINAL CHEMICAL COMPOSITION (wt%)

Ni	Cu	Mn	Fe
65.0	31.0	1.2	1.7

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)

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16" (1.6mm)	25# LWS	877062LWS00
1/8" (3.2mm)	25# COIL	877125COIL00