

## PRODUCT OVERVIEW

**PMET 889** is a nickel chromium titanium wire specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent corrosion resistance and good wear resistance. It is highly resistant to sulfur and vanadium atmospheres up to 1825° F. It has proven to be particularly effective as a protective arc spray coating for boiler tubes in black liquor recovery boilers and coal fired utility boilers.

### TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRC 30-35
⇒ Bond Strength:	7000 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	85%
⇒ Wire Coverage:	0.8 oz/ft <sup>2</sup> / mil
⇒ Surface Texture	* Variable
⇒ Machineability	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

- ⇒ Boiler Tubes
- ⇒ Corrosion Resistance

## NOMINAL CHEMICAL COMPOSITION (wt%)

### Solid Wire

Ni	Cr	Ti
56.3	43.0	0.7

### Cored Wire

Ni	Cr	Ti
50	49.3	0.7

## RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*30-32	*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
1/16" (1.6mm)	25# LWS	889062LWS00 (Solid Wire)
1/16" (1.6mm)	25# LWS	889062LWS02 (Cored Wire)