

PRODUCT OVERVIEW

PMET 899 is a pure (99.95%) molybdenum wire specifically designed for thermal spraying. It produces dense, well-bonded coatings with excellent wear resistance and good corrosion resistance. It is particularly effective for applications where scuffing or galling is a problem, such as piston rings, shift forks and synchronizing rings.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRC 15-35
⇒ Bond Strength:	7900 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	75%
⇒ Wire Coverage:	1.1 oz/ft ² / mil
⇒ Surface Texture	* Variable

* Depends on air pressure used

APPLICATION

- ⇒ Wear resistant coatings
- ⇒ Corrosion resistance
- ⇒ Anti galling

NOMINAL CHEMICAL COMPOSITION (wt%)

Mo

99.95

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.

SPECIFICATION

PWA 36913

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*32-34	*100-250	*3-7 in (7-17 cm)
**1/8" (3.2mm)	N/A	N/A	N/A	N/A

*Parameters are Typical and may vary depending on equipment used. Contact your equipment manufacturer for optimum spray parameters

** 1/8" used for combustion wire spray process

STANDARD SIZES & PACKAGING:

Diameter

- 1/16" (1.6mm)
- 1/8" (3.2mm)