

SP 1.8401

CATEGORY	Metal spray wires
TYPE	Copper coated solid thermal spray wire for coatings with high hardness.
APPLICATIONS	Machine parts, storage surfaces, shafts, cylinder surfaces etc..
PROPERTIES	Medium hard, wear resistant alloy with excellent lubricating and sliding properties with high bonding strength.
CLASSIFICATION	EN ISO 14700: S Fe1 DIN: W.Nr. 1.8401
SUITABLE FOR	Flame spray, electric spray and high speed flame spray.
APPROVALS	CE approved

SPRAY WIRE ANALYSIS (TYPICAL VALUES)

C	Si	Mn	Cr	Al	Ti
0.30	0.45	1.10	1.00	0.10	0.20

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
							~300

SPRAY PARAMETERS / PACKING

Parameters					Packing
D (mm)	Voltage (V)	Current (A)	Distance	Air pressure	kg / spool / Drum
1,6	32	100-200	15-22 cm	60 psi	15 kg K-300 / H-420 20 kg / 250 kg

REDRYING TEMPERATURE	not required
PREPARATION	The surface must be free from dirt, grit blasting in a 90 degrees angle with aluminum oxide usually offers the best results.