

## SP 80/20 NiCr

CATEGORY Metal spray wires

APPLICATIONS Ceweld SP 80/20 is a nickel-chromium electrical-resistance alloy for use at operating temperatures up to 2100°F (1150°C). It contains rare-earth additions for increased oxidation resistance, especially under conditions of frequent switching or wide temperature fluctuations. The alloy has a low temperature coefficient of resistance, making it suitable for control resistors. Used for heating elements in domestic appliances and industrial equipment. Excellently suitable as a buffer layer before finishing with ceramic layers.

CLASSIFICATION DIN: W.Nr. 2.4639

SUITABLE FOR NiCr metal spray wire for heat resistant coatings with excellent bonding strength.

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Fe	Si	Cr	S	Ni+Co
< 0.15	< 1.0	< 1.0	0.75-1.75	19-21	< 0.01	rem

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing
	Voltage (V)	Current (A)	kg / spool
1.6	29-32	100-250	15