CEWELD®

SP 95/5 (NiAl)

CATEGORY	Metal spray wires
TYPE	SP 95/5 is a Nickel-Aluminum based alloy for use as a bonding layer with the thermal spray process
APPLICATIONS	New coatings on macine parts and shafts to increase life, rebuilding wornout parts etc. Layer thickness: approximately 0.1- 0.15 mm.
PROPERTIES	This alloy offers the highest bonding properties available for both the Flame spray process as the Arc Spray process. The wire has a high polished and clean surface to assure the best feeding and thermal spray properties. Sprayed layers of this material are-resistant to variation in high temperatures and are used as a buffer layer for all other spraying alloys. Hardness, coating macro: approximately HRc 22. Maximum working temperature: approximately 850° C
CLASSIFICATION	AWS (UNS N03301)
SUITABLE FOR	Shafts, clutches, gliding surfaces, valves, bond coatings etc.
WELDING POSITIONS:	

PURE CAST ANALYSIS %

Al	Ni
5	95

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc
							22

WELDING PARAMETERS / PACKING

Process Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	28	100-250	K-300 / D-300	13-15
3.17	30	150-350	K-415 / H-420	25-27

REDRYING TEMPERATURE	not required