

SPA 55

CATEGORY Metal spray wires

TYPE Cored wire for the thermal spray process

PROPERTIES High-alloyed tubular wire for metal spray on a C-Cr carbide basis for hard and corrosion resistant deposits on parts subject to mineral abrasion. Excelent bonding strenght.

CLASSIFICATION

AWS	A 5.21: E FeCr-A1
EN ISO	14700: T FE-15
DIN	8555: MF 10-GF-55-GTRZ

SUITABLE FOR Cement industry, shafts, pumps, mixer blades, fans, sleeves, mixers, shear blades, boiler tubes etc.

WELDING POSITIONS:



SPRAY WIRE ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo
5.0	0.7	1.10	29	-	<0,15

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
							53-57

SPRAY PARAMETERS / PACKING

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

REDRYING TEMPERATURE 150°C/24hr

PREPARATION The surface must be free from dirt, grit blasting in a 90 degrees angle with aluminum oxide usually offers the best results.