

SPA 725

CATEGORY Metal spray wires

TYPE High-alloyed tubular wire based on a CCrMoNb alloy for thermal spray.

APPLICATIONS Applications that require Corrosion resistance in combination with high temperature and extreme wear.

PROPERTIES High wear resistance with complex carbide structure. The deposit gives a extreme high hardness and is suitable for corrosion protection, homogeneous particle distribution. The spray deposit is only machinable by grinding with diamond tools.

CLASSIFICATION EN ISO 14700: TFE special alloy

SUITABLE FOR Cement industry, pumps, mixer blades, valves seals, bearings, magnetic sensors, dimensional restoration.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo	Nb	Fe
<3.0	<3.0	<3.0	<30	<10	<10	Bal.

MECHANICAL PROPERTIES

Heat Treatment	Bonding strength ASTM C633	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
As sprayed							65-70

WELDING PARAMETERS / PACKING

Spray Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	31-33	150-200	BS-300	15
2,4	34	150-280	BS-300	15
3.2	36	220-400	K-415	25

REDRYING TEMPERATURE not required