

SPA 750

CATEGORY Metal spray wires

TYPE Seamless fluxcored medium alloyed metal spray wire for wear resistant layers with high hardness.

APPLICATIONS Agriculture, mining, cement industry, machine maintenance etc.

PROPERTIES Due to the high resistance to cracking and toughness, all spray metal requires no buffer layer except on materials considered critical. In this Situation Ceweld SP NiAl is recommended. Suited for wear parts subject to heavy abrasion. The interpass temperature should be maximum 250°C. The spray deposit is machinable by special carbide tools.

CLASSIFICATION EN ISO 14700: TFE-6

SUITABLE FOR Cones, presses, slides, shifts, pumps, sleeves, axes etc..

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo
0.30	1.50	0.60	5.50	0.90

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							50

Hardness fully depend on the spray parameters.

WELDING PARAMETERS / PACKING

D (mm)	Spray Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1.6	32	100-200	K-300	16	1024
2.4	34	150-280	K-300	16	1024
3.2	36	220-400	K-415	25	1024

REDRYING TEMPERATURE not required