

SPA 867

CATEGORY Metal spray wires

TYPE Seamless high-alloyed fluxcored wire on a C-B-carbide basis for extreme hard deposits on parts subject to severe mineral abrasion.

APPLICATIONS Suited for wear parts subject to extreme heavy abrasion.

PROPERTIES High wear resistance and similar structure as by C.-Cr. Carbide deposits. The deposit gives a extreme high hardness, all spray metal requires no buffer layer except on materials considered critical. In this Situation Ceweld SP NiAl is recommended. The spray deposit is only machinable by grinding.

CLASSIFICATION EN ISO 14700: TFE-16

SUITABLE FOR Cement industry, pumps, mixer blades, sleeves, mixers, shear blades and parts etc.

APPROVALS CE approved

WELDING POSITIONS:



SPRAY METAL ANALYSIS %

C	Mn	Si	Cr	B
1.8	0.8	0.6	8.1	4.2

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							62-70

SPRAY PARAMETERS / PACKING

D (mm)	Voltage (V)	Spray Parameters			air pressure	Packing kg / spool / drum
		Current (A)	Distance			
1.6	32	100-200	15-22 cm		60 psi	16 kg / K-300 / Drum
2.4	34	150-280	16-24 cm		60 psi	25 kg / K-415 / Drum
3.2	36	220-400	18-26 cm		60 psi	25 kg / K-415 / Drum

REDRYING TEMPERATURE not required