

SPA FeCrBSi

CATEGORY Metal spray wires

TYPE High-alloyed tubular wire on a Cr-B-Si basis for thermal spray (flame and electric)

APPLICATIONS Pulling, drawing tools, cable trolleys, fan blades, dies etc.

PROPERTIES High temperature resistance with low friction coefficient and excellent ductile coating structure, all spray metal requires no buffer layer. Recommended for coatings against erosion and corrosion.

CLASSIFICATION

AWS	A 5.21: special alloy
EN ISO	14700: special alloy
DIN	8555: special alloy

SUITABLE FOR Applications that require low friction in combination with high temperature resistance.

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	B	Fe
<0,10	0.6	1,85	29	3,8	Rem

MECHANICAL PROPERTIES

Heat Treatment	Bonding strength ASTM C633	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Micro Hardness HV0,1
				-20°C	-40°C	-60°C	
as sprayed	49,7 N/mm2						~1170

SPRAY PARAMETERS / PACKING

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

REDRYING TEMPERATURE 150` C / 24hr