

## SPA NiCrBSi

CATEGORY	Metal spray wires	
TYPE	High-alloyed tubular wire on a NiCrBSi alloy for thermal spray (flame and electric)	
APPLICATIONS	Applications that require Corrosion resistance in combination with high temperature applications.	
PROPERTIES	High temperature and corrosion resistance with excellent ductile coating structure, all spray metal requires no buffer layer. Recommended for coatings against erosion and corrosion and increased temperatures.	
CLASSIFICATION	AWS	A 5.21: special alloy
	EN ISO	14700: special alloy
	DIN	8555: special alloy

**SUITABLE FOR** Pulling, drawing tools, cable trolleys, fan blades, dies, food processing screws, extruders etc.

**WELDING POSITIONS:**

### WELD METAL ANALYSIS %

C	Mn	Si	Cr	B	Ni
0.8	0.1	4.2	14.2	3	Rem

### MECHANICAL PROPERTIES

Heat Treatment	Bonding strength ASTM C633	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Micro Hardness HV0,1
				-20°C	-40°C	-60°C	
as sprayed	45-53 N/mm <sup>2</sup>						

### SPRAY PARAMETERS / PACKING

Spray Parameters					Packing
D (mm)	Voltage (V)	Current (A)	Distance	Air pressure	kg / spool
1.6	30	100-200	15-22 cm	60 psi	15 / K-300
2.4	32	150-280	16-24 cm	60 psi	15 / K-300
3.2	34	220-400	18-26 cm	60 psi	25 / K-415

**REDRYING TEMPERATURE** 150` C / 24hr