Technical data sheet EN131025GB	Thermal spraying cored wire **HARDSPRAY 140-TS**	Welding Alloys

CLASSIFICATION

EN ISO 14919: 5 - 1.6 - 4

DESCRIPTION

- Metal cored wire specifically designed for thermal spraying by using wire arc spray process
- Amorphous alloy with fine particles
- Produces a hard coating exhibiting high resistance to abrasion and corrosion, thermal resistant
- High resistance to metal-to-metal friction
- Easy to polish to obtain a high chrome like finishing after grinding
- Excellent bonding properties
- Highly compact deposit
- High deposition rate

APPLICATIONS

HARDSPRAY 140-TS is mainly used for thermal spraying of parts subject to erosion, in gaseous environment, at high temperature up to 900 °C

Examples:
Pressure and conveyor screws, grinding areas, fans, casing, cyclones, etc.

CHEMICAL COMPOSITION OF DEPOSIT

C	Cr	Mo	Nb	W	B	Fe
1.2	22.0	4.0	3.5	6.5	4.5	Bal.

TYPICAL PHYSICAL AND MECHANICAL PROPERTIES

As-sprayed hardness: 820 - 1050 HV / (65 - 70 HRC)
Melting point: 1430 °C
Bond strength: 40 MPa @ 20 mils
Coating density: 6.7 g/cm^3

TYPICAL WIRE ARC SPRAY PARAMETERS (1.6 mm wire)

Arc load voltage: 31 V
Current intensity: 150 A
Standoff distance: 100 mm
Air pressure: 3.5 bar
Spraying rate: 3.5 kg/hour
Other parameters according to equipment.

STANDARD DIAMETERS (mm)

Diameters: 1.6 - 2.0 - 2.4 - 2.8 - 3.2 mm
Other diameters: please consult us

PACKAGING

Diameter	1.6 - 2.4 mm	2.4 - 3.2 mm
Spool type	BS 300	B 450
Weight	15 kg	25 kg

Other packaging: please consult us