

**Technical
data sheet**

EN131025GB

**Thermal spraying cored wire
HARDSPRAY NI CBS-TS****CLASSIFICATION**

EN ISO 14919: 6 - 1.6 - 4

DESCRIPTION

- Metal cored wire specifically designed for thermal spraying by using wire arc spray process
- Ni-Cr-B-Si alloy
- Outstanding wear and corrosion resistant protective coatings
- Excellent bonding properties
- Highly compact deposit
- High deposition rate

APPLICATIONS

HARDSPRAY NI CBS-TS is mainly used for components subject to wear and chloride attack up to 450 °C

Examples:

Boiler tubes, chemical plant, food industry, ect.

TYPICAL DEPOSIT ANALYSIS

C	Si	Cr	Mo	B	Ni
0.4	4.5	20.0	2.0	0.7	Bal.

TYPICAL DEPOSIT PHYSICAL AND MECHANICAL PROPERTIESAs-sprayed hardness: 700 - 800 HV_{0.1} / (60 - 64 HRC)

Melting point: 1070 °C

Bond strength: 40 MPa @ 20 mils

Coating density: 7.2 g/cm³**TYPICAL WIRE ARC SPRAY PARAMETERS (1.6 mm wire)**

Arc load voltage: 30 V

Current intensity: 200 A

Standoff distance: 150 mm

Air pressure: 3.5 bar

Spraying rate: 4.0 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