

**Technical
data sheet**

EN131025GB

**Thermal spraying cored wire
HARDSPRAY NI WC-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-B-Si matrix containing tungsten carbide particles
- Outstanding extreme abrasion resistance coating, even in corrosive environments
- Excellent bonding properties
- Highly compact deposit
- High deposition rate

APPLICATIONS

HARDSPRAY NI WC-TS is mainly used for high abrasion resistance on highly wear loaded surfaces

Examples:

Cutting edges, feeding screws, hammers, dredging parts, ect.

TYPICAL DEPOSIT ANALYSIS

C	Si	B	WC	Ni
0.4	5.0	2.0	62	Bal.

TYPICAL DEPOSIT PHYSICAL AND MECHANICAL PROPERTIESAs-sprayed hardness: Matrix: 450 - 590 HV / (45 - 55 HRC)
Carbides: 2200 - 2800 HV_{0.1}

Melting point: 1100 °C

Bond strength: 40 MPa @ 20 mils

Coating density: 11.0 g/cm³**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: 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