

**TH335 Iron**

**DESCRIPTION**

TH335 is a cored wire specifically designed for arc spray systems. It produces a well bonded coating with high hardness. It has the unique ability to produce either smooth or very rough profile coatings for non-slip applications. TH335 coatings have excellent machinability. Typical applications include non-slip coatings for walkways and stairs, gripping rolls and bond coats.

**TYPICAL DEPOSIT CHARACTERISTICS:**

- Bond Strength                      8000 psi
- Typical Hardness                 HRB 35
- Deposit Rate                        10 lbs./hr./100 Amps
- Deposit Efficiency                 80%
- Wire Coverage                      2 sq. ft./lbs. @ 12 mils
- Surface Texture                    Variable
- Machinability                        Good

**SURFACE PREPARATION:**

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. NOTE: It is best not to handle surfaces after cleaning. Recommended method of preparation is, to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe. \*Thermion recommends a 3.5 mil minimum anchor tooth profile.

**NOMINAL CHEMICAL COMPOSITION (wt. %):**

Al	C	Mn	Fe
5.5	2.0	0.8	Bal

**RECOMMENDED SPRAY PARAMETERS:**

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16 (1.6mm)	20-60 psi	32	100-150	4"-8" in

Parameters are typical and may vary depending on equipment used.

**STANDARD SIZES & PACKAGING:**

Diameter	Packaging
1/16 (1.6mm)	25#