

TH180 Iron Boride

DESCRIPTION

TH180 is an iron based general all-purpose cored wire with superior anti-erosion and abrasion performance. It can be easily and safely arc sprayed with air on site to all metal surfaces, including white cast iron.

TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 5800 psi
- Typical Hardness HRB 95-100
- Deposit Rate 18 lbs./hr./150-200 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.

Applications:

Dredge cutter blades
 Augers
 Conveyor flights
 Scraper blades
 Tool Joints

NOMINAL CHEMICAL COMPOSITION (wt. %):

Si	B	C	Fe
.02-1.0	6.1-9.5	.06-.60	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	26-28	280-300	*4-8 (10-20cm)

STANDARD SIZES & PACKAGING:

Diameter	Packaging
1/16 (1.6mm)	25#