

TH225 Nickel Series

DESCRIPTION

TH225 is a high purity nickel-chrome-moly wire specifically designed for arc spraying. It produces dense, well-bonded coatings with good resistance to corrosion.

TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 7000 psi
- Typical Hardness HRB 92
- Deposit Rate 18 lbs./hr./150-200 Amps
- Deposit Efficiency 70%
- 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:

- Oxidation and heat resistant coatings
- Corrosion resistance

NOMINAL CHEMICAL COMPOSITION (wt. %):

Ni	Cr	Mo	Fe	Cb+Ta
62.5	22	10.0	2.0	3.5

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16"	*50-60 psi	*28-32	*100-300	*4-8 in (10-20cm)

Parameters are typical and may vary depending on equipment used.

STANDARD SIZES & PACKAGING:

Diameter	Packaging
1/16" (1.6mm)	25#