

TH246 Nickel Aluminum Bronze**DESCRIPTION**

TH246 Nickel Aluminum Bronze is known for its high bond strengths and its ability to produce a dense and wear resistant coating. Nickel has been added to this material to increase its hardness as well as aid in its ability to resist mechanical and thermal shock. Additionally characteristics of this material would be its resistance to cavitation and high corrosion resistance.

TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 7000 psi
- Typical Hardness HRB 30-35
- Deposit Rate 18 lbs./hr./150-200 Amps
- Deposit Efficiency 85%
- 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:

- Saltwater Pumps
- Natural Gas Compression Piston and Cylinder Liner

NOMINAL CHEMICAL COMPOSITION (wt. %):

Cu	Al	Ni	Mg	Remain
81.5	9	4	1.5	.5

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	80-100 psi	28-32	100-300	4-7" (10-17cm)

Parameters are typical and may vary depending on equipment used.

STANDARD SIZES & PACKAGING:

Diameter Packaging
1/16 (1.6mm) 33#