



TH260 Nickel Tungsten Carbide

DESCRIPTION

TH260 is a nickel boron silicon matrix system, with 38-45% tungsten carbide particles. This combination produces a superior microstructure when welded and has excellent fine particle erosion, corrosion and toughness. The low heat input when welding this reduces the amount of tungsten carbide particles going into the solution. Deposits are not machinable and cannot be flame cut.

TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 5800 psi
- Typical Hardness 50-60 HRC
- Deposit Rate 18 lbs./hr./150-200 Amps
- Deposit Efficiency 80%
- Wire Coverage 2 sq. ft./lbs. @ 12 mils
- Surface Texture Variable
- Machinability No

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:

- Boiler Tubes & Tube Shields
- Fan Blades
- Dredge Rotary Cutter Heads
- Augers
- Rotors
- Other High Wear Application

NOMINAL CHEMICAL COMPOSITION (wt. %):

W	Si	B	Ni
38-45	2.2	1.0	Bal

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)	25#