

TH351 Stainless Chromium Carbide

DESCRIPTION

TH351 is a cored wire specifically designed for arc spray systems. It produces a hard, well bonded coating that is abrasive and corrosion resistant. TH351 can be easily machined with carbide tools, yielding a smooth, low coefficient of friction surface finish, suitable for a number of applications.

TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 5250 psi
- Typical Hardness HRC 55
- Deposit Rate 8 lbs/hr/100A
- Deposit Efficiency 70%
- Wire Coverage 1.0 oz/sq.ft/mil
- Surface Finish Grind**

***Grind using Aluminum Oxide*

SURFACE PREPARATION:

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. 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.

NOMINAL CHEMICAL COMPOSITION (wt%):

Cr	Si	C	Mn	Fe
28	1.0	5.0	1.0	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16 (1.6mm)	60 psi	32	100-200	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#