



## TH602 Aluminum Silicone

### DESCRIPTION

TH602 is a solid wire specifically designed for arc spray systems. It produces dense, well bonded coatings with excellent machinability. TH602 provides higher hardness and density than coatings produced with pure aluminum. This coating is used for dimensional restoration of aircraft engine parts and other aluminum based components.

### TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 5100 psi
- Typical Hardness HRB 70-75
- 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:

- Dimensional Restoration

### NOMINAL CHEMICAL COMPOSITION (wt. %):

Si	Al
4.5-6.0	Balance

### 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)	22# spool