

Characteristics and field of use

Flux cored wire for the arc spraying process.

Hard coating with good oxydation resistance.

Hardness as deposited: NA

Typical analysis in %

C	Mn	Si	Cr	Fe	B
4.5	0.7	1.3	26.0	balance	0.3

Welding instruction

Observe normal spraying practices, respiratory protection and proper air flow pattern advised.

For general spray practices, see AWS C2.1-73.

Thermal spraying is a completely safe process when performed in accordance with proper safety measures.

Become familiar with local safety regulations before starting spray operations.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Psi	Spray Dist [mm]
1.6	150 – 350	29 – 31	60 – 80	100 – 200