Technical Datasheet

PMET 273 Fe Cr B Si Amorphous

July 16, 2015

PRODUCT OVERVIEW

PMET 273 is a cored wire specifically designed for arc spray systems. It produces a partially amorphous, hard, abrasive and corrosion resistant coating, with a service environment up to 1700° F. High chrome like finishes can be obtained by typical grinding and lapping techniques. PMET 273 is used in a wide variety of high wear applications, anti-skid surfacing applications and corrosive environments.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRC 55-60
⇒ Bond Strength:	6000 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	70%
⇒ Wire Coverage:	1.0 oz/ft^2 / 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. **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.

APPLICATION

⇒ Boiler tubes & tube shields
⇒ Yankee Dryer Rolls
⇒ Anti-skid
⇒ Fan blades
⇒ Drill collars

NOMINAL CHEMICAL COMPOSITION (wt%)

Cr	B	Mn	Si	Fe
29.0	3.7	1.7	4.6	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16” (1.6mm)	*50-60 psi	*29-32	*100-200	4-8 in (10-20 cm)

* Parameters are typical and may vary depending on equipment used. Contact your equipment manufacturer for optimum spray parameters

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16” (1.6mm)	25# LWS	273062LWS01

7397 Union Centre Blvd. West Chester, OH 45014 / Phone: 513-874-3586 / Fax: 513-874-2880

E-mail: sales@polymet.us