

An Iron-Aluminum, Cored Wire Made Exclusively for the
Twin Wire Arc Spray Process

EuTronic Arc[®] 535 Wire



COATING

- Dense, well bonded coatings
- May be used as a rough, anti-skid coating
- Easily adjustable to achieve specific coating properties



DESCRIPTION:

535AS is an iron-aluminum, cored wire manufactured exclusively for the twin wire arc spray process. The coatings produced are suitable for two broad applications. First, 535 AS can be used as a dense, bond coating for subsequent top coatings, including galvanizing with zinc wire. Second, 535 AS can be used as a rough, anti-skid coating for a wide range of applications. The specific coating properties desired can be achieved by adjusting spray parameters and primarily by adjusting the atomizing air pressure.

TYPICAL COATING CHARACTERISTICS:

Typical Hardness:	35 HRC
Bond Strength:	8,000 psi
Coating Density:	6.78 g/cc
Deposition Rate:	10 lb/hr/100 Amps
Deposit Efficiency:	80 %
Wire Coverage:	Anti-Skid: 0.5 oz/ft ² /mil Dense, Bond Coating: 0.8 oz/ft ² /mil

SPRAY PARAMETERS:

Diameter:	1.6 mm
Air Pressure:	15 psi (Anti-Skid) 50 psi (Dense, Bond Coating)
Voltage:	27-30
Amperage:	200 -350
Stand-Off:	4" (Anti-Skid) 5" (Dense, Bond Coating)

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

PROCEDURE FOR USE:

Surfaces should be clean, white metal, with no oxides (rust), dirt, grease, or oil in the coating area.

Note: It is best not to handle parts after cleaning.

The recommended method of surface preparation is to grit blast with 24 mesh aluminum oxide.

APPLICATIONS:

As Non-Skid Coating:

- Ship deck
- Metal walkway
- Road construction plates
- Truck ramps
- Traction rolls

Bond Coating:

- Machine element repair

PACKAGING:

Wt: 25 # (11.34 kg)
Dia: 1/16 " (1.6 mm)
P.N. 535AS – 16 -11.34K

HEALTH & SAFETY:

To insure a safe work environment observe normal spraying practices, provide appropriate respiratory protection and pay attention to air flow patterns. For general spray practices, see AWS Publications AWS C2. 1-73, "Recommended Safe Practices for Thermal Spraying" and AWS TSS-85, "Thermal Spraying, Practice, Theory and Application." 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. DO NOT operate your spraying equipment or use the spray material supplied before you have thoroughly read the equipment instruction manual.

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Refer to the Eutectic web site for Material Safety Data Sheet (MSDS) information.

DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH

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