

An Aluminum - Bronze Wire Made Exclusively for the Twin Wire Arc Spray Process

# EuTronic Arc<sup>®</sup> 552 Wire



## COATING

- High bond strength
- Self-bonding to most metals including copper-base alloys
- Good abrasion and corrosion resistance
- Widely used for machine element repair



## DESCRIPTION:

Eutronic Arc 552 is an aluminum-bronze wire designed specifically for the Twin Wire Arc process. The coatings produced are characterized by high bond strength and are considered self-bonding to most metals including copper-base alloys. Eutronic Arc 552 will produce extremely dense coatings which exhibit good, general resistance to abrasion and corrosion. In addition, the coatings produced are readily machined to a 30-35 micro inch finish with standard high speed steel tooling. Eutronic Arc 552 coatings are widely used for machine element repair applications.

## APPLICATIONS:

- Bond Coating
- Rebuild Propeller Shafts (Aluminum Bronze Components)
- Rebuild Worn Bearing Areas
- Pump Shafts and Housings
- Air Seals

## TECHNICAL WIRE PROPERTIES:

Melting Point: 1800°F (982°C)

## TYPICAL COATING CHARACTERISTICS:

Nominal Hardness:	67 HRB
Bond Strength:	7000 psi
Deposit Rate:	9 lbs/hr/100 amps
Deposit Efficiency:	75%
Wire Coverage:	0.9 oz/ft <sup>2</sup> /0.001 inches thick
Coating Density:	6.3 gm/cc

## 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.

## SPRAY PARAMETERS:

Diameter:	1.6 mm
Air Pressure:	*50 – 60 psi
Voltage:	*20 – 21
Amperage:	*100-200
Standoff:	*4-8 in.

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

## 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.

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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