

An 18/5 stainless steel wire for Electric Arc Spray

# EuTronic Arc<sup>®</sup> 564 Wire



## COATING

- Dense, well bonded high integrity coatings
- Excellent machinability
- Good wear and corrosion resistance
- Low shrinkage makes it suitable for build up of inside diameters



## DESCRIPTION:

EuTronic Arc 564AS is an 18/5 stainless steel wire specifically designed for arc spraying. It produces dense, well-bonded low shrink coatings with excellent machineability and wear and corrosion resistance.

## TYPICAL APPLICATIONS:

- Hydraulic rams
- Inside diameters requiring heavy buildup
- Food industry rollers
- Machine element work

## TYPICAL COATING CHARACTERISTICS:

Bond Strength:	4350 psi (27.6 MPa)
Deposit Efficiency:	80%
Hardness:	90 to 95 HRB
Coating Density:	6.94 g/cm <sup>3</sup> (0.25 lb/in <sup>3</sup> )
Spray Rate:	10 lb/hr/100 amps
Wire Coverage:	0.8 oz/ft <sup>2</sup> /0.001"
Melting Point:	2600°F (1427°C)

## FINISHING:

EuTronic Arc 564AS coatings can be machined or ground to an excellent finish.

## PROCEDURE FOR USE:

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.

## ARC SPRAY PARAMETERS:

Air Pressure:	*50 - 60 psi <sup>(1)</sup>
Voltage:	*28 - 30
Amperage:	*100 - 200
Standoff	*4 - 6 in.

\* Parameters are typical and may vary depending on the equipment used.  
<sup>(1)</sup> 55 psi max when using ArcJet.

## AVAILABILITY:

25 lb per spool @ 1/16" diameter  
Part Number: 564AS-16-11.64K

## 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 "Safety and Health Fact Sheet No.20 - Thermal Spray Safety". 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.

Contact Eutectic for Material Safety Data Sheet (MSDS) information.

DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



**Eutectic Canada**  
*Eastern Canada*  
428, rue Aime Vincent  
Vaudreuil-Dorion, Quebec  
Phone: (800) 361-9439  
Fax: (514) 695-8793

**Eutectic Canada**  
*Western Canada*  
7722 - 69 Street  
Edmonton, Alberta  
Phone: (800) 661-3620  
Fax: (780) 465 8076

[www.eutectic.ca](http://www.eutectic.ca)

Statement of Liability: Due to variations inherent in specific applications, the technical information contained herein, including any information as to suggested product applications or results, is presented without representation or warranty, expressed or implied. Without limitation, there are no warranties of merchantability or of fitness for a particular purpose. Each process and application must be fully evaluated by the user in all respects, including suitability, compliance with applicable law and non-infringement of the rights of others, and Eutectic Corporation and its affiliates shall have no liability in respect thereof.  
564AS Aug2018 © 2018, Eutectic Canada, ® Reg. T.M., Printed in Canada.