

Stainless Steel Wire Made for the Eutronic Arc Spray Process

EuTronic[®] Arc 566 Wire



COATING

- Excellent machineability
- Strong, dense, well bonded coatings
- Excellent corrosion resistance
- Widely used for machine element repair and dimensional restoration



DESCRIPTION:

Eutronic Arc Spray 566 is a 316 stainless steel wire specifically designed for the arc spray process. 566 produces dense, well-bonded coatings with excellent machinability and corrosion resistance.

EAS 566 is widely used for machine element repair and dimensional restoration applications. It has relatively high shrinkage characteristics and should not be used for coatings over 0.075" in thickness. If greater thicknesses are required, first apply Eutronic Arc Spray 560 and finish with 566.

APPLICATIONS:

- Part Resoration
- Resurfacing
 - Paper mill cylinders
 - Rams
 - Shafts
 - Pump plungers

TYPICAL COATING CHARACTERISTICS:

Typical Hardness:	HRB 90-95
Bond Strength:	6,750 psi
Spray Rate:	10 lb/hr/100 amps
Deposit Efficiency:	75%
Wire Coverage:	0.8 oz/ft ² / mil
Surface Texture:	Variable (air pressure used)
Machineability:	Good

CHEMICAL COMPOSITION:

C	0.08
Mn	2.0
Ni	12.0
Cr	17
Si	1.0
Mo	2.5
Fe	Bal

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.

SPRAY PARAMETERS:

Diameter:	1/16" (1.6 mm)
Air Pressure:	*50 – 60 psi
Voltage:	*28-30
Amperage:	*100-200
Standoff:	*4-6 in. (10-15cm)

** 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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