



A Zinc 15% Aluminium Wire
Made Exclusively for the
Twin Wire Arc Spray Process

EuTronic® Arc

521 Wire



- A corrosion protection coating superior to Zinc and Aluminium coatings especially in atmospheric environments

EuTronic® Arc 521AS

EuTronic Arc 521AS is made exclusively for arcspraying; it is an alloy of 85 percent zinc and 15 percent aluminum and is not contaminated in the arc spray process.

The as-sprayed properties provide resistance to atmospheric corrosion. The applied coating can also be used for galvanizing applications and general oxidation resistance. It provides better corrosion resistance than zinc or aluminum wire alone.

TECHNICAL DATA

Typical Values	
Hardness:	73 HRB
Deposit Efficiency:	70%
Bond Strength:	3680 psi (25.4 MPa)
Melting Temperature:	824°F (440°C)
Density:	4.97 gm/cc
Spray Rate:	21 lb/hr/100 amps
Wire Coverage:	0.8 oz / ft ² /0.001"

Typical Composition:

Zinc:	85%
Aluminum:	15%

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.

EuTronic Arc 514AS coatings are used as-sprayed.

Please contact your Eutectic Surface Coatings Specialist for more information.

Spray Parameters:

Air Pressure:	*50 – 60 psi
Voltage:	*20-21
Amperage:	*100-300
Standoff:	*3-10 in.

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

Availability:

2.3mm, 3.2mm (1/8") and 4.8mm (3/16") diameter wire available on spools or in drums.

TYPICAL APPLICATIONS

This coating can be used in applications where zinc and aluminum coatings are being applied. Better corrosion protection is seen in atmospheric corrosion applications especially if crevice corrosion is likely to occur and where the coating may be scratched or scored in use.

For marine and freshwater applications where the coating will be immersed, the coating must be used with a sealer to allow long term corrosion protection.

To ensure a safe work environment observe normal welding practices, provide appropriate eye, hearing, skin and 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 T55-85, "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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