



A Manganese Compensated, Medium Carbon
Steel Wire Made Exclusively for the
Twin Wire Arc Spray Process

EuTronic® Arc 530 Wire



- Low cost solution to critical rebuild applications
- Coatings give excellent wear resistance in lubricated service
- Coatings can be finished by turning, machining and/or grinding

EuTronic® Arc 530AS

EuTronic Arc 530 is manganese compensated, medium carbon steel wire developed specifically for the Twin Wire Arc process. The coatings produced are suitable for a broad range of rebuild applications where hardness is not critical but where low coating cost is a limiting factor.

EuTronic Arc 530 is a medium shrink material. It will require special surface preparation techniques such as grooves at edges when used on flat surfaces at thicknesses greater than 0.030 inches. The use of EuTronic Arc 500 bond wire may reduce the need for special preparation techniques.

Coatings can be finished by turning, machining or grinding.

TECHNICAL DATA

Typical Values	
Typical Hardness:	95 HRB
Bond Strength:	5800 psi
Deposit Rate:	10lb/hr/100 amps
Deposit Efficiency:	80%
Wire Coverage:	0.8 oz/ ft ² /0.001 inch (wire consumption)
Coating Density:	6.78 g/cc
Shrink:	0.006 inch/inch
Thickness Limit:	0.080 inches
Melting Point:	2732°F (≈1500°C)

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 aluminium oxide.

Please contact your Eutectic Surface Coatings Specialist for more information.

Spray Parameters:

Diameter: *1.6 mm
Air Pressure: *50 – 60 psi
Voltage: *28-30
Amperage: *100-300
Standoff: *4-7 in.

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

TYPICAL APPLICATIONS

- Parts Restoration
- Bearing Surfaces
- Press Fits
- Valve Stems

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 T5S-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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