



A Nickel Chromium Molybdenum (C276) Wire
Made Exclusively for the
Twin Wire Arc Spray Process

EuTronic® Arc

546 Wire



- Dense, well bonded coatings with excellent corrosion resistance and stress corrosion cracking resistance in various alkaline, acidic and chloride environments
- Good resistance to abrasion and metal to metal wear

EuTronic® Arc 546AS

EuTronic Arc 546AS is high purity nickel chromium molybdenum tungsten (Alloy C276) wire specifically designed for arc spraying.

It produces dense, well-bonded coatings with excellent corrosion resistance and stress corrosion cracking resistance in various alkaline, acidic and chloride environments.

Its hardness makes it resistant to abrasion and resists metal to metal wear.

TECHNICAL DATA

Typical Values	
Hardness:	35 HRC
Deposit Efficiency:	70%
Bond Strength:	7000 psi (48 MPa)
Melting Temperature:	2400°F (1360°C)
Density:	7.2 g/cc
Spray Rate:	11 lb/hr/100 amps
Wire Coverage:	0.8 oz / ft ² /0.001"

Typical Composition:

Nickel, Chromium, Molybdenum, Iron, Tungsten

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, rough grind or rough machine in a lathe.

EuTronic Arc 546AS coatings can be machined or ground.

Please contact your Eutectic Surface Coatings Specialist for more information.

Spray Parameters:

Air Pressure: *50 – 60 psi
Voltage: *29-32
Amperage: *50-300
Standoff: *3-8 in.

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

Availability:

25 lb per spool @ 1/16" diameter
Part Number: 546AS-16-11.64K

TYPICAL APPLICATIONS

- Pump housings / casings, valves (chemical processing industry)
- Pulp and paper digesters
- Guide rolls
- Corrosive environments

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.



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

