



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

# **EuTronic® Arc**

## **547 Wire**



- Erosion, oxidation and corrosion resistance at temperatures up to 1600°F (870°C)
- Dimensional restoration of Inconel 625 and other nickel based superalloys
- Superior corrosion control in a broad range of acidic and chloride environments
- Good resistance to stress corrosion cracking

# EuTronic® Arc 547AS

EuTronic Arc 547AS is high purity nickel chromium molybdenum (Alloy 625) wire specifically designed for arc spraying.

It produces dense, well-bonded coatings with good erosion, corrosion and oxidation resistance at temperatures up to 1600°F (870°C). Coatings have good resistance to stress corrosion cracking in various caustic, acidic and chloride environments.

## TECHNICAL DATA

Typical Values	
Hardness:	92 HRB
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 <sup>2</sup> /0.001"

### Typical Composition:

Nickel, Chromium, Molybdenum, Iron, Niobium (Columbium) and Tantalum

## 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 547AS coatings can be machined with conventional tooling.

Please contact your Eutectic Surface Coatings Specialist for more information.

### Spray Parameters:

Air Pressure: \*40 – 50 psi (<sup>†</sup>)  
Voltage: \*28-30  
Amperage: \*100-200  
Standoff: \*4-6 in.

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

*(<sup>†</sup>) 55 psi max. when using ArcJet.*

### Availability:

1/16"(1.6 mm) diameter wire on 30lb. spools.  
Product Code: 547AS-16-11.36K

## TYPICAL APPLICATIONS

- Pulp and Paper Digesters
- Corrosive Environments
- Boiler Tubes
- Chemical Manufacturing Industry
- Incinerators

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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