



A Type 420 Stainless Steel Wire
Made Exclusively for the
Twin Wire Arc Spray Process

EuTronic® Arc **560 Wire**



- Excellent resistance to mild abrasion and corrosion
- Type 420 stainless steel wire
- Excellent for projects requiring thick coating build-up

EuTronic® Arc 560AS

EuTronic Arc 560 is a type 420 stainless steel wire specifically designed for the twin wire arc process. The coatings produced are dense, well bonded and exhibit excellent resistance to mild abrasion and corrosion. EuTronic Arc 560 coatings are widely used for machine element repair and dimensional restoration applications. The low shrink characteristics make EuTronic Arc 560 coatings an excellent choice for applications requiring a thick build-up.

Coatings of EuTronic Arc 560 can be finished using conventional carbide tooling to achieve a medium finish. Better results can be achieved via grinding with silicon carbide or aluminum oxide wheels (30-50 grit).

TECHNICAL DATA

Typical Values	
Typical Hardness:	42 HRC
Superficial Hardness:	R 15N 80-82
Bond Strength:	6500 psi
Deposit Rate:	10lb/hr/100 amps
Deposit Efficiency:	70% - 80% (parameter dependent)
Wire Coverage:	0.8 oz/ ft ² /mil (wire consumption)
Coating Density:	6.74 g/cc
Shrinkage:	0.0018 in/in
Surface Texture:	Variable (depends on spray parameters)
Melting Point:	2600°F (≈1427°C)
Wire Weight:	96 feet / lb @ 1/16 in diam.
Coeff. of Thermal Expansion:	6.6 X 10 ⁻⁷ in/in °F (up to 1000°F)
Wire Weight:	96 feet / lb @ 1/16 in. diam.

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.

Please contact your Eutectic Surface Coatings Specialist for more information.

Spray Parameters:

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

**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
Product Code: 560AS-16-11.34K

TYPICAL APPLICATIONS

- Cylinder Liners
- Journals
- Crankshaft Bearings
- Machine Elements, General
- Pistons
- Hydraulic Rams

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...

