



An 18/5 Stainless Steel Wire  
Made Exclusively for the  
Twin Wire Arc Spray Process

# **EuTronic® Arc**

## **564 Wire**



- Dense, well bonded high integrity coatings
- Excellent machinability
- Good wear and corrosion resistance
- Low shrinkage makes it suitable for build up of inside diameters

# EuTronic® Arc 564AS

EuTronic Arc 564AS is an 18/5 stainless steel wire specifically designed for arc spraying. It produces dense, well-bonded low shrink coatings with excellent machineability and wear and corrosion resistance.

## TECHNICAL DATA

Typical Values	
Hardness:	90 to 95 HRB
Deposit Efficiency:	80%
Melting Temperature:	2600°F (1427°C)
Bond Strength:	4350 psi (27.6 MPa)
Density:	6.94 g/cc (0.25 lb/in <sup>3</sup> )
Spray Rate:	10 lb/hr/100 amps
Wire Coverage:	0.8 oz/ft <sup>2</sup> /0.001"

## 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 564AS coatings can be machined or ground to an excellent finish.

Please contact your Eutectic Surface Coatings Specialist for more information.

### Spray Parameters:

Air Pressure: \*50 – 60 psi <sup>(1)</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>(1)</sup>55 psi max when using ArcJet.

### Availability:

25 lb per spool @ 1/16" diameter  
Product Code: 564AS-16-11.64K

## TYPICAL APPLICATIONS

- Hydraulic rams
- Inside diameters requiring heavy buildup
- Food industry rollers
- Machine element work

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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