



Stainless Steel Wire  
Made Exclusively for the  
Twin Wire Arc Spray Process

# **EuTronic® Arc**

## **566 Wire**



- Excellent machinability
- Strong, dense, well bonded coatings
- Excellent corrosion resistance
- Widely used for machine element repair and dimensional restoration

# EuTronic® Arc 566AS

EuTronic Arc 566AS is a 316 stainless steel wire specifically designed for the arc spray process. It produces dense, well-bonded coatings with excellent machinability and corrosion resistance.

EuTronic Arc 566AS is widely used for machine element repair and dimensional restoration applications. It has relatively high shrinkage characteristics and should not be used for coatings over 0.075" in thickness. If greater thicknesses are required, first apply EuTronic Arc Spray 560 and finish with EAS 566.

## TECHNICAL DATA

Typical Values	
Typical Hardness:	90-95 HRB
Bond Strength:	6750 psi
Spray Rate:	10 lb/hr/100 amps
Deposit Efficiency:	75%
Wire Coverage:	0.8 oz/ft <sup>2</sup> /mil
Surface Texture:	Variable (air pressure used)
Machinability:	Good

### Composition:

Cr, Ni, Mo, Mn, Si, C

## PROCEDURE FOR USE:

Surfaces should be clean, white metal, with no oxides (rust), dirt, grease, or oil in the coating area.

*Note: It is best not to handle parts after cleaning.*

The recommended method of surface 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.*

## TYPICAL APPLICATIONS

- Part restoration
- Resurfacing
  - Paper mill cylinders
  - Rams
  - Shafts
  - Pump plungers

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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