



High-grade, Tin-Based Wire  
Made Exclusively for the  
Twin Wire Arc Spray Process

# **EuTronic® Arc**

## **585 Wire**



- Perfect wire for Babbit bearing rebuilds
- Dense, well bonded coatings
- Designed for high speed applications

# EuTronic® Arc 585AS

EuTronic Arc 585 is a high-grade, tin-based wire specifically designed for use with the Twin Wire Arc Spray process. The coatings produced are dense, well bonded and suitable for use in applications requiring a high speed and heavy duty bearing surface.

The use of an intermediate, bond layer of 500AS may be helpful in applications where 585AS is being applied onto an existing poured Babbitt surface. The 500AS gives an exceptionally strong bond and provides a coarse surface for the 585AS wire coating. When possible, remove all old Babbitt material from the shell, apply a 500AS bond layer and complete with 585AS to the required thickness.

## TECHNICAL DATA

Typical Values	
Typical Hardness:	Negligible
Bond Strength:	3000 psi
Coating Density:	6.67 g/cc
Deposit Efficiency:	70%
Deposition Rate:	48 lb/hr/100 amps
Wire Coverage:	0.9 oz/ft <sup>2</sup> /mil
Surface Texture:	< 250 micro inches aa
Machinability:	Good
Shrinkage:	Negligible
Melting Point:	695°F (369°C)

### Wire Diameter:

5/64" (2.0mm)

1/8" (3.2mm) also available for combustion wire process

## PROCEDURE FOR USE:

Surfaces should be clean, white metal, with no oxides (rust), dirt, grease or oil in the coating area. When degreasing, use OSHA-approved degreasing solvents.

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

The recommended method of surface preparation on aluminum or magnesium parts is to grit blast with steel or cast iron shot. If aluminum oxide grit is used, keep the blast air pressure at 30 psi or lower.

Please contact your Eutectic Surface Coatings Specialist for more information.

### Spray Parameters:

Diameter:	1/16" (1.6 mm)
Air Pressure:	*50 – 60 psi
Voltage:	*21-23
Amperage:	*100-200
Standoff:	*4-8 in.

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

## TYPICAL APPLICATIONS

- Rebuilding Babbit bearing surfaces

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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