

AI-1855

Description and Applications

AI-1855 is an austenitic, low carbon stainless steel wire produced exclusively for metal spraying. It has excellent corrosive resistant properties and good machineability. It can be sprayed with most guns.

Applications: is used where a dense machineable coating is required. Seal rings, gland casings valve plugs etc. have been sprayed successfully.

Typical Analysis

C	Mn	Si	Cr	Ni	Fe	S	P
0.09	7.25	0.40	19.00	9.00	Bal	0.02	0.03

Properties

	As sprayed
Deposit Efficiency	83%
Melting Point	1,425°C approx..
Bond Strength	48 MPa (7000 psi)
Coating Tensile Strength	243 MPa (35,300 psi)
Coating Texture	Variable*
Hardness	94 Rb
Coating Density	6.94 gm/cm ³ **
Shrink	0.008cm/cm approx..
Finish	Ground or Machine Finished

* Depends on air pressure, standoff, nozzle cap and target size.

**Depends on atomizing air pressure.

Parameters

	Volts	Amps	Air	Distance
Bond Pass	Use AI 1800 Bond Arc for bond wire			
Build Up	26-30	100-250	414-621kPa (60-90psi)	150-175mm

NOTE: Be sure not to overheat substrate as this reduces coating quality. If necessary, stop to allow cooling or use air jet cooling if greater speed is required.

Available Sizes

1.6mm, 3.2mm and 4.8mm diameter.

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au



ALLOYS INTERNATIONAL PTY LTD

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 |

ABN 53 112 712 286

sales@alloysint.com.au | www.alloysint.com.au