

AI-1866

Description and Applications

AI-1866 is a high quality steel wire produced exclusively for metal spraying, where a coating must be machined.

AI-1866 is a low shrink material which can be sprayed to whatever thickness is required. It will not crack. It is, therefore, THE material to use where a coating will have to endure plenty of wear.

Applications: **AI-1866** is used on machine parts such as armature shafts, journal surfaces and parts that have been mis-machined previously.

AI-1866 can also be ground finished if required, thus taking advantage of its superior shrink properties.

Typical Analysis

C	Mn	Cr	Fe	P	S	Mo
0.07	1.10	2.70	Bal	0.02	0.02	1.00

Mechanical Properties

	As sprayed
Tensile Strength	228 MPa (33,000psi)
Melting Point	870°C approx..
Hardness	220HB approx..
Coating Density	6.78 gm/cm ³ **
Shrink	0.002cm/cm approx..
Coating Finish (Machined)	Excellend

Spray Parameters

	Volts	Amps	Air	Distance
Bond Pass	Use AI 1800 Bond Arc for bond wire			
Build Up	30-32	150-350	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.

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



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