

ARCWEL BABBITT 90-SN-AS ARC SPRAY WIRE

GENERAL CHARACTERISTICS AND APPLICATIONS:

Solid Tin based lead free Babbitt type (Bearing Metal) wire.

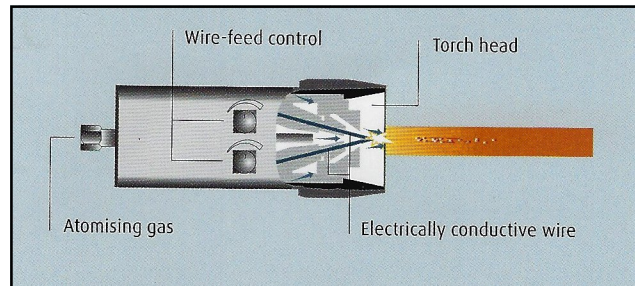
- Superior antifriction alloy with excellent fatigue resistance.
- Coatings are ductile, low oxide, and are of bright metallic appearance
- Use for coating of high speed and heavy duty bearing surfaces
- Good compatibility with most lubricants.
- May be applied by arc spray, flame spray or GTAW (TIG)
- **Typical applications are Diesel engine bearings, Propeller shaft bearings, High speed turbine bearings, Gearboxes etc.**
- Alloy conforms to ~ ASTM –B 23-00 (2014) /~UNS L 13890 /Grade 2

TYPICAL CHEMICAL COMPOSITION [%]

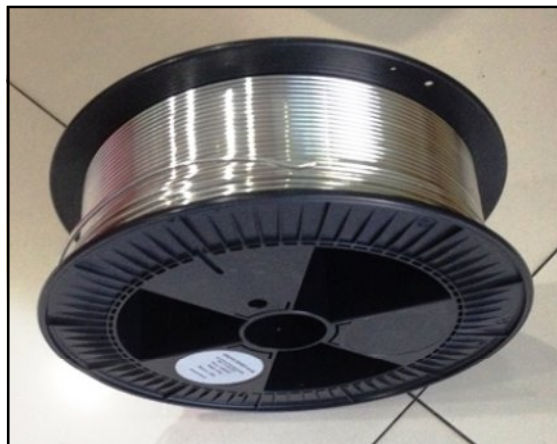
| Sn | Sb | Cu | Fe |
|------|-------|---------|--------|
| Bal. | 6.5-7 | 3.4-3.6 | ≤0.006 |

FORM OF DELIVERY

| Ø [mm] | Spool weight [kg] | Spool type |
|--------|-------------------|------------|
| 3. | 10 kg | D300 |
| 2 | 10 kg | D 300 |



FOR ELECTRIC ARC SPRAY PROCESS



BABBITT 90 SN-AS SPOOL



**BEARING HOUSING REPAIR with
ARCWEL BABBITT 90 SN –AS**

Disclaimer

The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties. Arcwel reserves the right to alter specification without further notice.

Health & Safety : Observe safety regulations (fumes) MSDS available on request

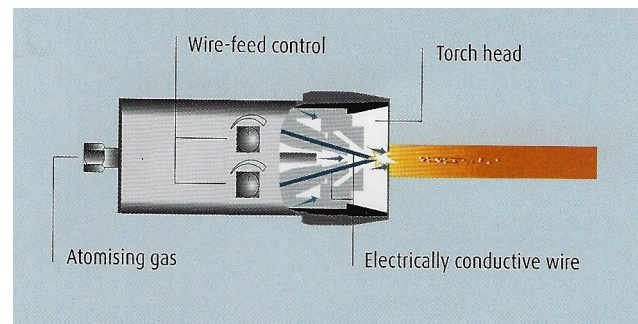
www.arcwel.com E-mail: info@arcwel.at

TECHNICAL DATA

- ◆ Nickel –Aluminium Wire (flux-cored) BONDING WIRE
- ◆ Used for Bonding coats on different metals such as aluminum ,steel, stainless steel, nickel , cast iron , and titanium
- ◆ Excellent bonding (up to 62 Mpa) and good impact strength
- ◆ High temperature resistance
- ◆ Melting point 1450 C , Deposit efficiency +- 70 %
- ◆ Spray rate: up to 4.5 kg/hour at 100 amps.

CHEMICAL COMPOSITION [%]

| | |
|----|-----|
| Ni | Al |
| 95 | Bal |



FORM OF DELIVERY

| Ø [mm] | spool weight [kg] | spool size |
|--------|-------------------|----------------------------|
| 1.6 | 12- 15 | SD 300 K plastic spools |

Procedure for use

The work piece to be coated must be perfectly clean and have grit blasted surface.

Spray parameters must be adapted to the thermal spraying system used

The sprayed coating may be used without post machining however it can be ground and polished according to the required surface finish specifications.

Attention: for best feeding performance use wire feed rolls with dental grooves

Health and safety:

Thermal spray processes generate dust and fumes which may be harmful to health.

Spraying should therefore be done in closed well ventilated areas equipped with filter collectors and appropriate respiratory devices.

Operators must be protected according to local safety regulations

MSDS available on request

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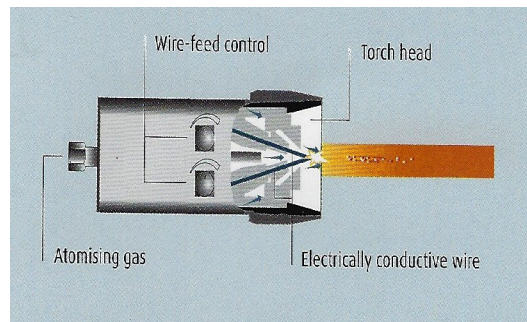
ARCWEL 630-AS ARC SPRAY WIRE

For protection of boiler equipment against corrosion and erosion

- **CHROME BORON** alloyed flux cored wire used for spraying of coatings requiring high resistance to abrasion, erosion and corrosion.
- Superior coating quality ,abrasion resistance and integrity
- Longer service life of coated component
- Use for coating of fan blades, Boiler tubes, pump components, printing rolls, economizer water walls, seal rings, ,piping, evaporators etc.

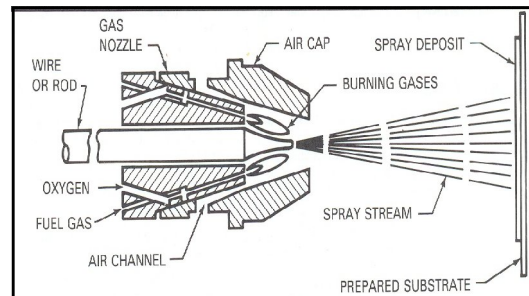
CHEMICAL COMPOSITION [%]

| Cr | B | Si | Mn | Fe |
|-------|-----|-------|---------|------|
| 28-30 | 3-4 | 1-1.5 | 0.6-1.5 | Bal. |



FOR ELECTRIC ARC SPRAY ING

| Technical Data | Typical Values |
|-------------------------------|----------------|
| Hardness (HV 0.1) | 1000-1200 |
| Deposition Rate | 2.3 kg/h 100 A |
| Melting Point | 1204 C |
| Deposit efficiency | ~70 % |
| Service temperature (°C) max. | Up to 870 |



FOR WIRE FLAME SPRAYING

FORM OF DELIVERY :

| Ø [mm] | Spool weight [kg] | Spool Typ |
|--------|-------------------|-----------|
| 1.6 | 15 | BS 300 |

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