

DM HardBond TWAS

PRODUCT TYPE : A HIGH QUALITY PROPIETARY SELF- BONDING, HARD, ABRASIVE AND CORROSION RESISTANT CORED WIRE FOR TWIN WIRE ARC SPRAY (TWAS)

APPLICATIONS : Used as a protective coatings on yankee dryer rolls, steel rolls, piston rods and applicable on a wide variety of high abrasive and corrosive wear operating environment.

CHARACTERISTICS :

- Coating exhibit high hardness and toughness with excellent bond strength
- Forms a unique composite coating with hard amorphous / nanocrystalline structure
- Excellent resistance to abrasion and particle erosion at elevated temperature
- Less fumes and higher DE compared to standard amorphous material during spraying
- Can be spray as a Pseudo Alloy in combination with DM 18 Cr TWAS for super finish

TYPICAL CHEMISTRY :

ELEMENT	C	B	Cr + Nb + Ni	others	Fe
% BY WEIGHT	5.0	< 5.0	< 50.0	< 5	Bal.

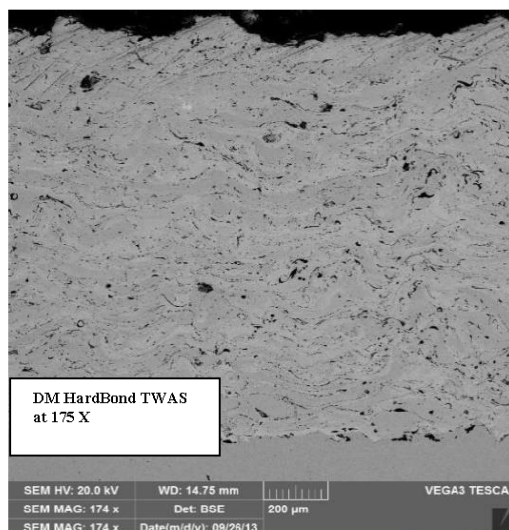
SURFACE PREPARATION :

Clean and degrease surface to be spray. NOTE : Surface should be clean with no oxides (rust), dirt, grease, or oil on the surface to be coated DO NOT handle blasted surface after cleaning. It is recommended to grit blast surface with 18-24 mesh aluminum oxide.

MECHANICAL PROPERTIES :

Bond Strength	> 70,000 MPa
Typical Hardness	65 – 70 HRC
Deposition Efficiency	< 80 %
Spray Rate	11–12 kg /hr
Wire Coverage	1 kg /m ² /100 µm

AVAILABLE FORM : 1.6mm in spool



Diameter	Air Pressure	Voltage	Amperage	Standoff
1.6mm	* 50 psi to 75 psi	*29-32 V	*175-250 A	10-20 cm

** Parameters varies from different equipment manufacturer*

Diam.	15 kg Spool
1.6mm	TalarcHardbond

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