

Thermal Spray Wires Technical Bulletin

SG 527 Fe 29Cr

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Applicable for:  Arc Spray  Flame Spray

PRODUCT INFORMATION

Iron Chrome 29 cored wire is designed to produce very dense, highly erosion resistance surfaces that can be used to resist chemical attack from corrosive environments, even at elevated temperatures. The coating can also be honed or lapped to high surface finishes.

NOMINAL CHEMICAL COMPOSITION (%)

Fe	Bal
Cr	29.0
Mn	2.0
B	4.0
Si	2.0

WIRE PROPERTIES

∅ Wire	1/16 inch (1.6mm)
Morphology	Composite

COATING FEATURES (nominal data)

Hardness	HRC 55-60
Bond Strength	6000 PSI
Coverage	1 oz/ ft ² / mil
Deposition Efficiency	70%

PACKAGING

Spool	Paperboard
Weight	25 lbs ± 1 lb.

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CoatingSolutions@Saint-Gobain.com | www.coatingsolutions.saint-gobain.com

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APPLICATIONS

- Boiler tubes and tube shields
- Yankee Dryer Rolls
- Anti-skid
- Fan Blades
- Drill Collars

SURFACE PREPERATION

Surface should be clean, white metal, with no oxidation, oil, grease or dirt on the surface. Recommended method of preparation is to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe. Note: It is best not to handle the surface after cleaning.

