

ARCTEC® PRO 3000 Bond Coat

Ecoface Low Temperature Spray Powder



GENERAL CHARACTERISTICS:

ARCTEC® PRO 3000 is a high quality, economical bond coat. For use on all metals except pure copper. Produces metallurgical bond at temperatures below 500° F (260° C).

APPLICATIONS:

ARCTEC® PRO 3000 is excellent for use as a bond coat on cylindrical, shaft, journals and bearing surface. Apply as initial layer prior to applying final powder coating.

WELDING PROCEDURE:

Clean and degrease part thoroughly. Set up in lathe (preferable between centers). Undercut worn area plus 1/2" on either side. Thread undercut area. Fine threads 0.10" deep, course thread 0.30" deep. Leave about 1/16" land between end of thread and end of undercut. Do not touch after machining. Use pressure setting of 5 psi acetylene and 6 psi oxygen and adjust flame to slightly carburizing. Position torch horizontal to workpiece at a distance of 6-7". With work rotating in lathe a 50-125 rpm preheat base metal to 220°F. Start and finish deposit 3/4" beyond undercut area. Apply .005"-.007" maximum thickness.

MECHANICAL PROPERTIES:

OPERATING PARAMETERS:

WELDING PROCESS: FLSP (Flame Spray)

RECOMMENDED PRESSURE SETTINGS:

Acetylene 5 psi
:
Oxygen: 6 psi

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