

ARCTEC® PRO 3028
Ecoface Low Temperature Spray Powder



GENERAL CHARACTERISTICS:

ARCTEC® **PRO 3028** is a high quality, economical aluminum bronze finish coat. Fully machinable, wear resistant, self-lubricating, low friction finish coat for bearing surfaces on all metals (except pure copper).

APPLICATIONS:

ARCTEC® **PRO 3028** is excellent for build up on cylindrical surfaces that require low friction, self-lubricating and bearing surfaces.

WELDING PROCEDURE:

Apply over **PRO 3000** bond coat. Use pressure setting of 5 psi acetylene and 11 psi oxygen. Adjust torch flame to slightly oxidizing. 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. Traverse back and forth, fully covering bond coat area to required thickness plus .020". Do not overheat and do not exceed 700°F. Use 600-650°F tempilstick to check temperature. Allow to air cool in lathe before finishing. Finish using standard carbide tool.

MECHANICAL PROPERTIES:

HARDNESS: 80-85 RB

MACHINABILITY: Use tungsten carbide tool

OPERATING PARAMETERS:

WELDING PROCESS: FLSP (Flame Spray)

RECOMMENDED PRESSURE SETTINGS:

Acetylene: 5 psi

Oxygen: 11 psi

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