

ARCTEC® PRO 3055
Ecoface Low Temperature Spray Powder



GENERAL CHARACTERISTICS:

ARCTEC® **PRO 3055** is an economical, high quality spray powder. This spray powder has high resistance to abrasion and corrosion. Suitable for all metals except pure copper.

APPLICATIONS:

ARCTEC® **PRO 3055** is suited for build up on cylindrical surfaces subjected to abrasion and corrosive chemical reaction.

WELDING PROCEDURE:

Apply over **PRO 3000** bond coat. Use pressure setting of 5 psi acetylene and 6 psi oxygen. Adjust torch 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. 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: 80-92 RB

MACHINABILITY: Use tungsten carbide tool

OPERATING PARAMETERS:

WELDING PROCESS: FLSP (Flame Spray)

RECOMMENDED PRESSURE SETTINGS:

Acetylene 5 psi
:
Oxygen: 6 psi

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