

ARCTEC® PRO 3060
Ecoface Low Temperature Spray Powder



GENERAL CHARACTERISTICS:

ARCTEC® **PRO 3060** is a low carbon austenitic chrome nickel alloy. This spray powder has resistance to corrosion and high temperature oxidation. Suitable for all metals except pure copper.

APPLICATIONS:

ARCTEC® **PRO 3060** is suited for build up on pistons, valves and other cylindrical surfaces subjected to corrosion

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: 83-92 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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