

Classifications

GENERAL RECOMMENDATIONS

Arc-spraying cored wire designed to produce a hard abrasive and corrosion resistant coating up service temperature of about 900°C.

Hazards Observe normal spraying practices, respiratory protection and proper air flow pattern advised.

For general spray practices, see AWS C2.1-73.

Thermal spraying is a completely safe process when performed in accordance with proper safety

Become familiar with local safety regulations before starting spray operations.

Field of use

SK 848-M is used primarily as a hard corrosion resistant interface. We recommended to apply thickness not exceeding 12mm.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0.06	2.2	1.8	28.5	5.4	BAL

Typical mechanical properties

Hardness as deposited: NA

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Psi	Spray Dist
1,6	150-350	29-31	60-80	100-200