

## Characteristics and field of use

SK 858-M is a unique Nickel and Aluminium wire produced specifically for the production of a high quality, high tensile bondcoat for use exclusively with the arc spray process.

Bondcoat.

Hardness as deposited: NA

## Typical analysis in %

	Ni	Al
Pure deposited metal	balance	5.0

## Welding instruction

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 measures.

Become familiar with local safety regulations before starting spray operations.

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Psi	Spray Dist [mm]
1.6*	100 – 300	29 – 31	60 – 80	100 – 200

\*available on request