

Characteristics and field of use

SK 860-MF is a cored wire made exclusively for Arc Spraying, especially developed for spraying with subsequent fusion. It is a Ni-base alloy with addition of Boron and Silicon.

Application needing a high resistance to abrasive wear combined with corrosion.

Hardness as deposited: NA

Typical analysis

Ni, Cr, B, Si

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	40 – 60	100 – 200

*available on request