

Characteristics and field of use

SK 868-M is a cored wire made exclusively for arc spraying which when applied will provide a coating with an extreme resistance to corrosion caused by gases and ashes containing sulphur and Vanadium compounds resulting from high temperature combustion.

Boiler pipes.

Hardness as deposited: NA

Typical analysis in %

Cr	Ni	Ti
45.0	balance	4.0

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