

# WISDOM Thermal Spray Consumables

## Iron base alloy



**SS 200S**

**DATA SHEET**

November 2015

**DESCRPTION:**

Wisdom SS200S is an 18/5 stainless steel wire specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent machine ability and wear and corrosion resistance. SS200S is widely used for machine element repair, dimensional restoration and wear resistance applications.

**TYPICAL DEPOSIT CHARACTERISTICS:**

- Typical Hardness        HRB 90-96
- Bond Strength            4350 psi
- Deposit Rate             10 lbs /hr/100A
- Deposit Efficiency        80%
- Wire Coverage            0.8 oz/ft<sup>2</sup> / m
- Surface Texture         \*Variable
- Machine ability         Good

**SURFACE PREPARATION:**

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. Note: It is best not to handle surfaces after cleaning.  
Recommended method of preparation is, to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.

**APPLICATION:**

- Part Restoration
- Rams & Food Industry Rolls

**CHEMICAL COMPOSITION (wt%):**

	Cr	Ni	Mn	Si	Fe	C
	18	5	8.5	1.0	Bal	0.15

**RECOMMENDED SPRAY PARAMETERS:**

Diameter	Air Pressure	Voltage	Amperage	Standoff
1.6mm	*50 - 60 psi	*28 - 30	*100 - 300	*3 – 6 in (8- 15cm)

\* Parameters are typical and may vary depending on equipment used. Contact your equipment manufacture for optimum spray parameters.

**STANDARD SIZES & PACKAGING:**

Diameter	Dimension Tolerance	Packing	Wire Weight
1/16"(1.6mm)	+0/-0.05	D 300 Spool	15kgs(33 lbs)/spool
2.0mm	+0/-0.05	D 300 Spool	15kgs(33 lbs)/spool
1/8"(3.17mm)	+0/-0.05	Coil Form	20-400kgs/coil