

HPP Powders

Cold Spray POWDERS 635,665,685 606 Bond Coat

Specially formulated powders for all low temperature powder spray torches.

635 – Aluminum Bronze –

A copper based alloy powder for build-up on metal surfaces.
Excellent for coating soft bearing surfaces & provides excellent hard surface wear and friction properties.
Can be built up to thicknesses in excess of 0.250"

Technical: Deposit Hardness – RB 65 to 75
 Melting Temperature 1900 °F (1040°C)
 Bonding Temperature min 200 °F over bond coat

Applications: Soft bearing surfaces,
 Worn-out or mis-machined parts
 Pistons & housings, hydraulic press sleeves

665 – Nickel base inconel –

A nickel base alloy powder for build up that is machinable
Provides excellent corrosion, oxidation & friction wear.
Can be built up to thicknesses in excess of 0.125"

Technical: Deposit Hardness – RB 75 to 83
 Melting Temperature 1900 °F (1040°C)
 Bonding Temperature min 200 °F over bond coat

Applications: General purpose build-up
 Crank shafts, journals, impeller shafts

685 – Chrome Nickel –

A chrome nickel base alloy powder for hard wear & cavitation resistance.
Excellent for abrasion and metal to metal wear. Deposits are grindable
Can be built up to thicknesses in excess of 0.080"

Technical: Deposit Hardness – RC 32 to 39
 Melting Temperature 1850 °F (1010°C)
 Bonding Temperature min 200 °F over bond coat

Applications: Hard surface shafts
 Wear plates, spindles,

606 Bond Coat – Underlayment Bonding Compound

Nickel based self bonding powder used as initial thin layer on oxide-free clean surfaces (except copper).
Provides excellent surface adhesion and bonding to the overlay cold spray powder.
Excellent for copper base alloys, low alloy steels & heat treatable alloys
Bond coat layer .004" to .010"

Technical: Bond Strength on smooth surface 3500 psi

Note: FOR ALL COLD SPRAY PROCEDURES

MAX BASE METAL TEMPERATURE – 500°

