



Stainless Steel Wire  
Made for the Eutronic Arc  
Spray Process

# **EuTronic® Arc** **565 Wire**



- Excellent machineability
- Strong, dense, well bonded coatings
- Excellent wear and corrosion resistance
- Widely used for machine element repair, dimensional restoration and anti-wear applications

# EuTronic® Arc 565AS

EuTronic Arc Spray 565 is an austenitic stainless steel wire specifically designed for arc spraying. It produces dense, well-bonded coatings with excellent machineability and wear and corrosion resistance.

EuTronic Arc Spray 565 is widely used for machine element repair, dimensional restoration and wear resistance applications. It has relatively high shrink characteristics and should not be used for coatings over 0.075 inches thick.

## TECHNICAL DATA

Typical Values	
Hardness:	100 HRB
Deposit Efficiency:	75%
Bond Strength:	4,600 psi (31.7 MPa)
Spray Rate:	10 lb/hr/100 amps
Wire Coverage:	0.8 oz/ft <sup>2</sup> / mil
Surface Texture:	Variable (air pressure used)
Machineability:	Good

## PROCEDURE FOR USE:

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 aluminium oxide, rough grind or rough machine in a lathe.

### Spray Parameters:

Air Pressure: \*50 – 60 psi  
Voltage: \*28-30  
Amperage: \*100-200  
Standoff: \*4-6 in.

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

### Availability:

25 lb per spool @ 1/16" diameter  
Product Code: 565AS-16-11.64K

## TYPICAL APPLICATIONS

- Hydraulic rams
- Inside diameters requiring heavy buildup
- Food industry rollers
- Machine element work

To ensure a safe work environment observe normal welding practices, provide appropriate eye, hearing, skin and respiratory protection and pay attention to air flow patterns. For general spray practices, see AWS Publications AWS C2. 1-73, "Recommended Safe Practices for Thermal Spraying" and AWS T55-85, "Thermal Spraying, Practice, Theory and Application." 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. DO NOT operate your spraying equipment or use the spray material supplied, before you have thoroughly read the equipment instruction manual. Refer to the Eutectic web site for Material Safety Data Sheet (MSDS) information. . DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH.



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