




CEWELD SP 95/5 (NiAl)

TYPE	SP 95/5 is a Nickel-Aluminum based alloy for use as a bonding layer with the thermal spray process												
APPLICATIONS	New coatings on machine parts and shafts to increase life, rebuilding wornout parts etc. Layer thickness: approximately 0.1- 0.15 mm.												
PROPERTIES	This alloy offers the highest bonding properties available for both the Flame spray process as the Arc Spray process. The wire has a high polished and clean surface to assure the best feeding and thermal spray properties. Sprayed layers of this material are-resistant to variation in high temperatures and are used as a buffer layer for all other spraying alloys. Hardness, coating macro: approximately HRc 22. Maximum working temperature: approximately 850 °C												
CLASSIFICATION	EN ISO 14919: 6.5												
SUITABLE FOR	Shafts, Clutches, Gliding surfaces, Valves, Bond coatings etc.												
APPROVALS	No Approvals Found												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Mn</td> <td style="width: 16.6%;">Ti</td> <td style="width: 16.6%;">Fe</td> <td style="width: 16.6%;">Al</td> <td style="width: 16.6%;">Ni</td> </tr> <tr> <td>0.2</td> <td>0.2</td> <td>0.2</td> <td>0.1</td> <td>5.2</td> <td>Rem.</td> </tr> </table>	Si	Mn	Ti	Fe	Al	Ni	0.2	0.2	0.2	0.1	5.2	Rem.
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 12.5%;">R_{p0,2} MPa</td> <td style="width: 12.5%;">R_m MPa</td> <td style="width: 12.5%;">A₅ (%)</td> <td style="width: 37.5%;">Hardness Brinell Hardness</td> </tr> <tr> <td>As Welded /</td> <td></td> <td></td> <td></td> <td>Avg. 75</td> </tr> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Brinell Hardness	As Welded /				Avg. 75		
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As Welded /				Avg. 75									
REDRYING TEMPERATURE	Not required												
GAS ACCORDING EN 14175	None												