

Bulletin

Praxair Surface Technologies
1555 Main Street
Indianapolis, IN 46224

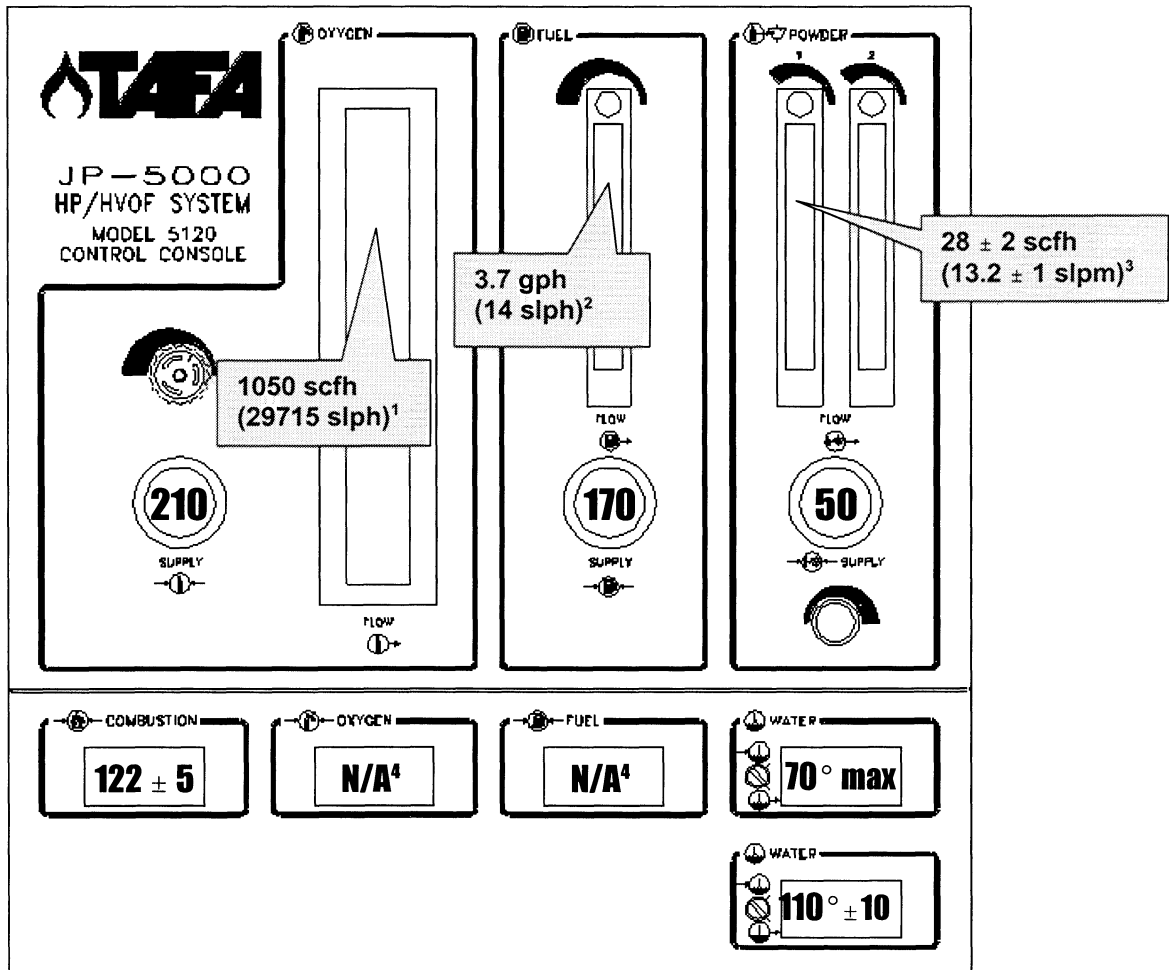
Praxair Surface Technologies
TAFE Incorporated
146 Pembroke Road
Concord, NH 03301

Spray Parameters

TAFE 1350VF Tungsten Carbide – 10 Cobalt – 4 Chromium

Although spray parameters vary, the following settings are recommended as good starting points for this coating. Some modifications may further enhance the coating quality.

Spray System:	JP-5000 HP/HVOF	Spray Rate:	7.3 lb/hr (55 g/min)
Gun Barrel:	4" Stainless Steel	Feeder Speed:	200 rpm (6 Pitch Screw)
Spray Distance:	6" (152 mm)	Coating Thickness:	0.050" (1.3 mm) Maximum



- Oxygen Flow** - The above flow setting is based on 210 psi supply pressure. For different supply pressures, use the Pressure Correction Chart in the Operation Section of the Manual to determine the correct flow for scfh specified above.
- Fuel Flow** - Users of older control consoles with a 0 to 100% tube in the fuel flowmeter should consult TAFE for the correct settings.
- Carrier Flow** - The needle valve above the powder feeder flowmeter should be left wide open and the flow should be adjusted with the needle valve on the console flowmeter. All flow rates are for nitrogen.