



Commercial Powder

Metal Group – **ALUMINUM**
 Catalogue No. – **SST-A5006**



Description:

Aluminum Silicon Alloy powder (AA4047, SST Catalog No. SST-A5006) with special particle size distribution for cold spray processes with general applications in salvage and restoration of aluminum and magnesium components. The cold spray coating presents high density, excellent bonding strength on magnesium alloy substrate, and good machinability.

Specifications:

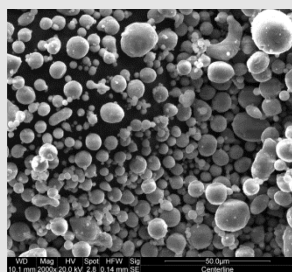
Material Properties

Composition: **Al12Si 99% Min.**
 Particle Size: **-45 to +5 µm**
 Characteristics: **Spherical particles**

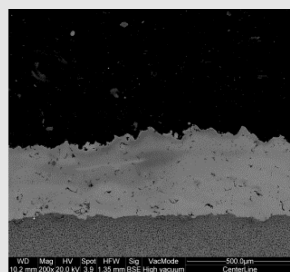
Typical Coating Properties

Bond Strength: **> 9500 psi**
 Deposition Efficiency: **Up to 27% (with powder heater)**
 Deposition Rate: **Up to 10 g/min**
 Hardness (Brinell): **89 – 97**
 Density: **> 97%**

Typical Micrograph



SST-A5006 Powder



SST-A5006 Coating on Mg alloy (Series EP)

Ordering Information

Catalogue Number: **SST-A5006**
 Standard Packaging: **400 ml or 1 gallon sized container**
 Selling Unit: **Pound**
 Material Certification: **Available upon request**

Recommended Spray Parameters

(when utilizing CenterLine Cold Spray equipment. Recommendations may not apply when making use of non-CenterLine equipment)

Series EP

Temperature: **450 – 500°C**
 Pressure: **450 – 500 psi**
 Powder Pre-heating*: **≤ 350°C**
 Standoff Distance: **10 – 40 mm**
 Gas: **Nitrogen**
 Feed Rate (gram/min.): **12 – 50**
 Gun Traverse Speed: **10 – 200 mm/s depending on process settings and target coating thickness**
 Surface Preparation: **SST-G0002 commercial blast or grease free as-machined surface**
 Spray Nozzle: **UltiFlow™**

To discuss your Cold Spray Application(s) or for more information about powders and blends, please contact your CenterLine SST representative or visit our website at www.supersonicspray.com.

* Notice for Powder Heater Use

Due to the specific material characteristics of this powder, equipment settings that deviate from the **Recommended Spray Parameters** listed above may result in clogging the powder heater. These parameters are based on 10 minutes of continuous spray time. For applications that require continuous spray times exceeding 10 minutes, please consult with CenterLine to receive assistance in optimizing spray parameters. Note that the SST Spray Machine and Gun User's Manuals also contain information on proper settings and operating parameters.