



PowderJet 86 Spraying Tables

SPRAYING TABLE – US SYSTEM

PPS Powder	Metco EQ #	Nozzle	Pressure Psi		Flow		Carrier Gas		Powder Feeder		Spray Distance	Deposit Efficiency	Hourly Consumption		
			Oxy	Acet	Oxy	Acet	Press.	Flow	Wheel	RPM			Lbs.	Oxy.	Acet
1	1a	2	3	4	5	6	7	8	9	10	11	12	13	14	15
PWD00002	44	CM	32	15	45	55	55	37	S	34	8	85	14	95	59
PWD00003	51	CM	32	15	45	55	55	37	S	28	8	95	14	95	59
PWD00004	451	CM	32	15	45	55	55	37	S	23	8	95	12	95	53
PWD00005	41C	CM	32	15	45	55	55	37	S	38	8	95	12	95	59
PWD00006	42C	CM	32	15	45	55	55	37	S	25	8	95	10	95	59
PWD00008	14E	CM	32	15	45	55	55	37	S	35	8	95	20	95	59
PWD00012(NOTE 1)	442	CD	25	15	42	50	55	37	S	12	10	85	5	82	49
PWD00013	443	CM	32	15	45	55	55	37	S	12	7	80	6	95	59
PWD00014	444	CD	25	15	42	50	55	37	S	12	9	85	5	82	49
PWD00015	445	CM	32	15	45	55	55	37	S	12	4-7	90	5	95	59
PWD00017	447	CM	32	15	45	55	55	37	S	10	4-7	90	4.5	95	59
PWD00019	449	CD	25	15	42	50	55	37	S	12	9	85	5	82	49
PWD00011-450	450	CM	32	15	45	55	55	37	S	12	7	90	6	95	59
PWD00033	43C	CM	32	15	45	55	55	37	S	22	8	90	10	95	59
PWD00101	15E	CM	32	15	45	55	55	37	S	35	8	95	20	95	59
PWD00102	16C	CM	32	15	45	55	55	37	S	35	8	95	20	95	59
PWD00103	19E	CM	32	15	45	55	55	37	S	25	8	95	18	95	59
PWD0012C	12C	CM	32	15	45	55	55	37	S	30	8	95	20	95	59

HIGH SPRAY RATE TABLE – US SYSTEM

PPS Powder	Metco EQ	Nozzle	Lighting Pressure PSI		Flowmeter Readings		Carrier Gas		Powder Feed Unit		Spray Dist.	Deposit Efficiency %	Hourly Consumption		
			Oxy	Acet	Oxy	Acet	Oxy	Acet	Wheel	RPM			Pwd. Lbs.	Oxy. Fl ₃	Acet. Fl ₃
1	1a	2	3	4	5	6	7	8	9	10	11	12	13	14	15
PWD00012	442	CK	30	15	42	50	55	37	S	20	12	85	10	82	49
PWD00013	443	CK	30	15	42	50	55	37	S	30	9	80	15	82	49
PWD00014	444	CK	30	15	42	50	55	37	S	30	9	85	15	82	49
PWD00015	445	CK	30	15	42	50	55	37	S	20	7	90	10	82	49
PWD00017	447	CK	30	15	42	50	55	37	S	30	9	90	15	82	49
PWD00019	449	CK	30	15	42	50	55	37	S	20	9	90	10	82	49
PWD00011-450	450	CK	30	15	42	50	55	37	S	20	9	90	15	82	49



PowderJet 86 Spraying Tables

* NS powders use the same settings as the powder of the same number without the NS suffix.

Notes:

1. Substrate preheat is critical. Preheat to 250-300 degrees.
2. Consumptions shown are optimal values obtained by skilled operators with equipment in 1st class condition.
3. Deposit efficiency figures are approximate and rounded for easy calculation. Where accurate figures are important, special on the job test runs are advised.

Concentrating Nozzle Setup Chart – US System

Lighting Pressure PSI		Flowmeter Reading		Carrier (N2)		Spray Rate	Spray Distance
Oxy.	Acet.	Oxy.	Acet.	Press. Psi	Flow		
30	15	45	50	55	37	*	6"

* Use published spray rates as a starting point. For self-fluxing alloys, reduce by 30%.



PowderJet 86 Spraying Tables

SPRAYING TABLE – METRIC SYSTEM

PPS Powder	Metco EQ #	Nozzle	Pressure Bar		Flow		Carrier Gas		Powder Feeder		Spray Distance	Deposit Efficiency	Hourly Consumption		
			Oxy	Acet	Oxy	Acet	Press.	Flow	Wheel	RPM			Kgs.	Oxy.	Acet
1	1a	2	3	4	5	6	7	8	9	10	11	12	13	14	15
PWD00002	44	CM	2.2	1.0	45	55	3.8	37	S	34	205	85	6.5	2.7	1.7
PWD00003	51	CM	2.2	1.0	45	55	3.8	37	S	28	205	95	6.4	2.7	1.7
PWD00004	451	CM	2.2	1.0	45	55	3.8	37	S	23	205	95	5.4	2.7	1.7
PWD00005	41C	CM	2.2	1.0	45	55	3.8	37	S	38	205	95	5.4	2.7	1.7
PWD00006	42C	CM	2.2	1.0	45	55	3.8	37	S	25	205	95	4.5	2.7	1.7
PWD00008	14E	CM	2.2	1.0	45	55	3.8	37	S	35	205	95	9.1	2.7	1.7
PWD00012(NOTE 1)	442	CD	1.7	1.0	42	50	3.8	37	S	12	255	85	2.3	2.3	1.4
PWD00013	443	CM	2.2	1.0	45	55	3.8	37	S	12	180	80	2.7	2.7	1.7
PWD00014	444	CD	1.7	1.0	42	50	3.8	37	S	12	230	85	2.3	2.3	1.4
PWD00015	445	CM	2.2	1.0	45	55	3.8	37	S	12	105-175	90	2.3	2.7	1.7
PWD00017	447	CM	2.2	1.0	45	55	3.8	37	S	10	105-175	90	2.0	2.7	1.7
PWD00019	449	CD	1.7	1.0	42	50	3.8	37	S	12	230	85	2.3	2.3	1.4
PWD00011-450	450	CM	2.2	1.0	45	55	3.8	37	S	12	180	90	2.7	2.7	1.7
PWD00033	43C	CM	2.2	1.0	45	55	3.8	37	S	22	205	90	4.5	2.7	1.7
PWD00101	15E	CM	2.2	1.0	45	55	3.8	37	S	35	205	95	9.1	2.7	1.7
PWD00102	16C	CM	2.2	1.0	45	55	3.8	37	S	35	205	95	9.1	2.7	1.7
PWD00103	19E	CM	2.2	1.0	45	55	3.8	37	S	25	205	95	8.2	2.7	1.7
PWD0012C	12C	CM	2.2	1.0	45	55	3.8	37	S	30	205	95	9.1	2.7	1.7

HIGH SPRAY RATE TABLE – METRIC SYSTEM

PPS Powder	Metco EQ #	Nozzle	Lighting Pressure Bar		Flowmeter Readings		Carrier Gas		Powder Feed Unit		Spray Dist. mm	Deposit Efficiency %	Hourly Consumption		
			Oxy	Acet	Oxy	Acet	Oxy	Acet	Wheel	RPM			Pwd. Kgs.	Oxy. m ³	Acet. m ³
1	1a	2	3	4	5	6	7	8	9	10	11	12	13	14	15
PWD00012	442	CK	2.1	1.0	42	50	3.8	37	S	20	305	85	4.5	2.2	1.3
PWD00013	443	CK	2.1	1.0	42	50	3.8	37	S	30	230	80	6.8	2.2	1.3
PWD00014	444	CK	2.1	1.0	42	50	3.8	37	S	30	230	85	6.8	2.2	1.3
PWD00015	445	CK	2.1	1.0	42	50	3.8	37	S	20	180	90	4.5	2.2	1.3
PWD00017	447	CK	2.1	1.0	42	50	3.8	37	S	30	230	90	6.8	2.2	1.3
PWD00019	449	CK	2.1	1.0	42	50	3.8	37	S	20	230	90	4.5	2.2	1.3
PWD00011-450	450	CK	2.1	1.0	42	50	3.8	37	S	20	230	90	6.8	2.2	1.3



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