

100 HE Plasma Parameters													
Alloys and PM				Hardware		Gas SLM			Power	Powder Feed		Torch	
Powder	Composition	Particle Size	Nozzle	Pwdr Ports	Ext Attach	Ar	N2	H2	GV/KW	Gr/min	Cr Gas	Stnd Off	
SM 52 CNS	AlSi 88/12	45-90 micron	866695	Med-.073	3-Port	85	45	33	213/70	150	33	11.5 cm	
SM 58 NS	CuNiIn	45-75 micron	868648	Long-.073	3-Port	85	47	66	262/95	50	12	17.8 cm	
SM 58 NS	CuNiIn	45-75 micron	841121	N/A	N/A	141	47	8	233/55	50	8	11.5 cm	
SM 404 NS	NiAl 80/20	53-90 micron	866695	Med-.100	3-Port	94	47	57	235/90	150	25	15.0 cm	
SM 404 NS	NiAl 80/20	53-90 micron	866695	Med-.100	3-Port	85	47	66	225/90	80	25	15.0 cm	
SM 450 NS	NiAl 95/5	45-90 micron	866695	Med-.100	3-Port	85	57	66	236/95	120	20	15.0 cm	
SM 450 NS	NiAl 95/5	45-90 micron	841143	Short-.100	3-Port	94	47	38	214/90	95	7	11.5 cm	
HC 281.863	NiAl 95/5	45-90 micron	841143	Short-.100	2-Port	85	47	66	240/95	80	8	15.0 cm	
SM 443 NS	NiCrAl	45-125 micron	866695	Med-.100	3-Port	85	57	66	238/95	120	23	15.0 cm	
SM 447 NS	NiMoAl	45-90 micron	866695	Med-.100	3-Port	76	57	66	234/95	120	21	15.0 cm	
Carp 718	CoNiCrAlY	45-106 micron	841121	N/A	N/A	113	45	19	200/65	85	8	11.5 cm	
Carp 718	CoNiCrAlY	45-106 micron	841121	N/A	N/A	141	47	28	231/45	70	10	11.5 cm	
HC 415.220	CoNiCrAlY	5-45 micron	866695	Med-.073	3-Port	104	47	66	224/85	80	6	15.0 cm	
SM 995 C	CoNiCrAlY	45-75 micron	841121	N/A	N/A	118	47	28	234/75	85	7	11.5 cm	
SM 461	NiCrAlCoY	45-106 micron	841143	Short-.100	2-Port	104	47	28	220/70	100	6	11.5 cm	
SM 9625 F	NiCrAlY	22-45 micron	868648	Med-.073	2-Port	85	47	66	250/95	75	10	14.0 cm	
SM 66 F T-400	CoMoCr	15-45 micron	868648	Med-.073	2-Port	94	47	66	250/95	100	10	15.0 cm	
Stellite T-400	CoMoCr	5-44 micron	866695	Med-.100	2-Port	113	47	66	250/95	50	8	12.7 cm	
PX T-800	CoMoCrSi	10-45 micron	841121	N/A	N/A	141	47	28	227/60	60	17	11.5 cm	
Stellite T-800	CoMoCrSi	5-44 micron	868648	Long-.073	2-Port	95	47	70	350/95	100	17	11.5 cm	
Carp 316 SS	FeCrNiMo	22-53 micron	841121	NA	N/A	150	45	28	227/75	100	7	11.5 cm	
Carp 316 SS	FeCrNiMo	22-53 micron	868648	Long-.073	2-Port	94	47	57	242/95	85	10	14.0 cm	
Hog 316 SS	FeCrNiMo	5-45 micron	841121	NA	NA	150	45	28	205/40	90	12	11.5 cm	
Hog 316 SS	FeCrNiMo	5-45 micron	841143	Short-.100	2-Port	113	47	42	225/90	105	9	11.5 cm	
SM 41 C	FeCrNiMo	45-106 micron	841121	NA	NA	113	42	8	200/75	85	7	14.0 cm	
WC 63 HV	NiCrBSi/CrC	15-45 micron	868648	Long-.073	2-Port	76	57	66	265/95	80	10	15.0 cm	
Armacor C	CrNiBMoCuSi	15-45 micron	868648	Long-.073	2-Port	113	57	47	254/95	100	14	11.5 cm	
Armacor M	FeCrNiBMoCuSi	15-45 micron	868648	Long-.073	2-Port	113	57	47	254/95	100	12	11.5 cm	
Nano SHS	Proprietary	15-45 micron	841121	NA	NA	165	47	28	230/50	75	12	11.5 cm	
HC Mo B4273	Pure Molybdenum	5-44 micron	866695	Med-.073	3-Port	104	57	57	243/95	70	10	15.5 cm	
HC Mo Bond	Pure Molybdenum	30-45 micron	866695	Med-.073	3-Port	76	38	24	211/40	70	6	15.5 cm	