

100 HE Plasma Parameters												
Alloys and PM				Hardware		Gas SCFH			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	180	90	70	213/70	150	70	4.5 in
SM 58 NS	CuNiIn	45-75 micron	868648	Long-.073	3-Port	180	100	140	262/95	50	25	7.0 in
SM 58 NS	CuNiIn	45-75 micron	841121	N/A	N/A	300	100	40	233/55	50	16	4.5 in
SM 404 NS	NiAl 80/20	53-90 micron	866695	Med-.100	3-Port	200	100	120	235/90	150	54	6.0 in
SM 404 NS	NiAl 80/20	53-90 micron	866695	Med-.100	3-Port	180	100	140	225/90	80	54	6.0 in
SM 450 NS	NiAl 95/5	45-90 micron	866695	Med-.100	3-Port	180	120	140	236/95	120	42	6.0 in
SM 450 NS	NiAl 95/5	45-90 micron	841143	Short-.100	2-Port	200	100	80	214/90	95	15	4.5 in
HC 281.863	NiAl 95/5	45-90 micron	841143	Short-.100	2-Port	180	100	140	240/95	80	18	6.0 in
SM 443 NS	NiCrAl	45-125 micron	866695	Med-.100	3-Port	180	120	140	238/95	120	48	6.0 in
SM 447 NS	NiMoAl	45-90 micron	866695	Med-.100	3-Port	160	120	140	234/95	120	45	6.0 in
Carp 718	CoNiCrAlY	45-106 micron	841121	N/A	N/A	240	90	40	200/65	85	18	4.5 in
Carp 718	CoNiCrAlY	45-106 micron	841121	N/A	N/A	300	100	60	231/45	70	22	4.5 in
HC 415.220	CoNiCrAlY	5-45 micron	866695	Med-.073	3-Port	220	100	100	224/85	80	12	6.0 in
SM 995 C	CoNiCrAlY	45-75 micron	841121	N/A	N/A	250	100	60	234/75	85	15	4.5 in
SM 461	NiCrAlCoY	45-106 micron	841143	Short-.100	2-Port	220	100	60	220/70	100	25	4.5 in
SM 9625 F	NiCrAlY	22-45 micron	868648	Med-.073	2-Port	180	100	150	250/95	75	22	5.5 in
SM 66 F T-400	CoMoCr	15-45 micron	868648	Med-.073	2-Port	200	100	150	250/95	100	22	6.0 in
Stellite T-400	CoMoCr	5-44 micron	866695	Med-.100	2-Port	240	100	140	250/95	50	18	5.0 in
PX T-800	CoMoCrSi	10-45 micron	841121	N/A	N/A	300	100	60	227/60	60	35	4.5 in
Stellite T-800	CoMoCrSi	5-44 micron	868648	Long-.073	2-Port	200	100	150	350/95	100	35	4.5 in
Carp 316 SS	FeCrNiMo	22-53 micron	841121	NA	N/A	320	95	60	227/75	100	15	4.5 in
Carp 316 SS	FeCrNiMo	22-53 micron	868648	Long-.073	2-Port	200	100	120	242/95	85	22	5.5 in
Hog 316 SS	FeCrNiMo	5-45 micron	841121	NA	NA	320	95	60	205/40	90	25	4.5 in
Hog 316 SS	FeCrNiMo	5-45 micron	841143	Short-.100	2-Port	240	100	90	225/90	105	20	4.5 in
SM 41 C	FeCrNiMo	45-106 micron	841121	NA	NA	240	90	40	200/75	85	15	5.5 in
WC 63 HV	NiCrBSi/CrC	15-45 micron	868648	Long-.073	2-Port	160	120	140	265/95	80	22	6.0 in
Armacor C	CrNiBMoCuSi	15-45 micron	868648	Long-.073	2-Port	240	120	100	254/95	100	30	4.5 in
Armacor M	FeCrNiBMoCuSi	15-45 micron	868648	Long-.073	2-Port	240	120	100	254/95	100	25	4.5 in
Nano SHS	Proprietary	15-45 micron	841121	NA	NA	350	100	60	230/50	75	25	4.5 in
HC Mo B4273	Pure Molybdenum	5-44 micron	866695	Med-.073	3-Port	220	120	120	243/95	70	20	6.0 in
HC Mo Bond	Pure Molybdenum	30-45 micron	866695	Med-.073	3-Port	160	80	50	211/40	70	12	6.0 in