

SPRAY WELDING



MECHANICAL BOND METHOD

- 1 Item to be repaired is machined only 1mm – 0.5mm deep to allow minimum thickness of spray material, far less than the original hard facing depth of up to 2mm.
- 2 Areas not to be sprayed are masked with either ordinary masking tape or special paste.
- 3 Spray welding is used for reclamation of SEAL areas or press fit areas for bearings only. Spray welding is **NOT** used to reclaim roller or needle bearing areas.
- 4 Spraywelding uses a mechanical bond rather than a fusion bond, that is it 'grips' the parent item as opposed to melting the parent item and fusing together.
- 5 Maximum temperature is approximately 105°C and the sprayed item can be removed from the chuck by hand in most instances.
- 6 Items to be spray welded are **NOT** preheated to 700° or greater (cherry red) as some other forms of shaft reclamation require.
- 7 Sprayed area is re-sized to specification by machining in a lathe.
- 8 *Driveline* has been using this method of seal area reclamation since 1999 with no issues.