



**EAGLE P 33**  
**SPRAY ALLOY POWDER**  
An economical high quality build-up powder.

**APPLICATIONS**

The **Eagle P 33** is a high quality tough nickel base powder for build-up on steels, bushings, key ways, gear teeth, sprocket teeth, cams, rollers, glass molds, plastic molds, patterns, brick molds and debarker knives.

**PROCEDURE**

The surface to be sprayed should be cleaned and free of oil, grease, and scale. Use a grinder to remove oxides. Preheat base metal to 400<sup>0</sup>F. Use a 1 – 1½ inch slightly carburizing flame and pre spray the area to be coated to a thickness of .004. Release the feed lever. Heat until a sweating action occurs. Weave torch and add P 33 powder to meet dimension required. Cool slowly.

**GENERAL CHARACTERISTICS**

The **Eagle P 33** is a tough nickel based powder that is fully machinable and is used for build-up on steels, nickel alloys and cast iron. This alloy can be used as an under-lay for hardfacing overlays.

**TECHNICAL DATA**

Hardness: (RC)	Approximate 15 – 20
Machinability:	Excellent
Weldability:	Excellent

[www.eaglealloys.ca](http://www.eaglealloys.ca)