	PRODUCT SPECIFICATION	Ref No. : PDS/930
	TITLE: KHOSLA 85/15 (Zn/Al) SUPER DELUXE QUALITY SPRAY WIRE	ISSUE NO. : 02 DATE : 01.01.2026 PAGE : 01 of 02

1. SCOPE: This specification covers manufacturing of "KHOSLA 85/15 (Zn/Al)" spray wire used for arc and flame spraying and are well-known for its excellent quality.

2. GENERAL: "KHOSLA' 85/15 Zn/Al" spray wire is manufactured from virgin special high grade zinc and aluminum ingots by the process which ensures that the material meets requirement of the specification. The manufactured wire should have a smooth finish, free from defects that may affect the feeding of the wire to the spray gun.

3 .1 CHEMICAL COMPOSITION:

The material consists

- 85% ± 1 % (weight) SHG Zinc with Purity of 99.995% as per BS EN 1179
- 15% ± 1 % (weight) Aluminum with Purity of 99.50% min. as per EN 573-3 grade EN AW-1050A
- Material Purity is as per ISO 14919:2015

	Standard Specification	Maximum Impurities (%)							
		Si	Pb	Fe	Cd	Sn	Cu	Pb+Cd	Total
Zn/Al	ISO 14919	0.12	0.007	0.02	0.004	0.001	0.01	0.011	0.1700

3.2 Properties: -

Properties	Requirement
Density	5.73 g/cm^3
Melting Point	382-440^{0}c
Electrical Resistance at 20^{0}c	5.13 x 10^{-8} Ohm.m
Elongation after rupture	70-200 %
Tensile Strength	90-160 mm^2

3.3 Hazardous Substance Control: -

The Material must fulfill REACH & ROHS Requirements, according to date revision.
Material mess following hazardous substance threshold concentration limits.

Substance	Concentration Limits	Substance	Concentration Limits
Lead (Pb)	<1000ppm	Bromine (Br)	<900ppm
Mercury(Hg)	<1000ppm	Chloride (Cl)	<900ppm
Cadmium (Cd)	<100ppm	Sum of Bromide and Chlorine	<=1500 ppm max
Hexavalent Chromium	<1000ppm	Antimony	<900ppm
Polybrominated Biphenyl (PBB)	<1000ppm	Red Phosphorous	<100ppm
Polybrominated Diphenyl Ether (PBB)	<1000ppm		

	PRODUCT SPECIFICATION	Ref No. : PDS/930 ISSUE NO. : 02 DATE : 01.01.2026 PAGE : 02 of 02
	TITLE: KHOSLA 85/15 (Zn/Al) SUPER DELUXE QUALITY SPRAY WIRE	

4. TOLERANCE ON DIMENTION: -

Dimensions in mm

Nominal Diameter	Tolerance
≤ 3	-0.05
≥ 3 Ø ≥ 4	-0.08

5. APPLICATION: -

"'KHOSLA' 85/15 Zn/Al" Spray wire is used in arc and flame spray. The combination of 85/15 combines the galvanic protection properties of zinc sacrificing itself in preference to the steel. The aluminum provides a passive barrier protection together. The zinc and aluminum provides an excellent corrosion resistant sprayed coating.

6. PACKING: -

"KHOSLA KHOSLA' 85/15 Zn/Al" spray wire are packed and supplied in,

1. 25-30 kg coil.
2. 100-200 kg, paper fiber drum.
3. 300-350Kg Metal drum.

7. HANDLING AND STORAGE:

KHOSLA' 85/15 Zn/Al spray wire to be stored in cool and dry place and should be kept away from direct water contact or heavy moisture area.

8. SHELF LIFE:-

"KHOSLA' 85/15 Zn/Al" spray wires have infinite shelf life. We recommend best for use within one year of manufacturing to get best results in application.

Prepared By : **HOD Q.A.**	**Approved By :** **Vice President (Ops.)**
First time issued; 19.07.2016	**Control Copy No.**