



INDUSTRIAL HARDWARE

AND SPECIALTIES INCORPORATED

Vacuum Cadmium

[MIL-C-8837B]

Used primarily to provide corrosion resistance to ferrous parts to be free from hydrogen contamination and possible embrittlement. Recommended on steels 220,000 psi or above. Coating is applied after all machining, brazing, welding and forming has been completed.

Prior to coating, all steel parts shall be stress relieved by baking at $375^{\circ} \pm 25^{\circ}\text{F}$ for 3 hours if suspected of having residual tensile stresses. Immediately prior to coating, lightly dry abrasive blast areas to be coated.

Cadmium coating shall not be used, if in service, temperature reaches 450°F .