

**Table 6.4.2 C: Advantages and Disadvantages of ESD for Repair of Worn Parts**

<b>Advantages</b>	<b>Disadvantages</b>
Inexpensive, portable, can repair-in-place	Very slow
Can get into very small spaces and re-entrant geometries	Some materials (carbides) self-limiting in thickness
Wide variety of coating materials	Coating has high tensile stress; cracks common, fatigue debit
Hand-held or robotic	Rough surface; sometimes have to file between layers
Very thin heat-affected zone (HAZ)	