CORODUR® SP 100

Flux cored wires for Thermal Spray Application
EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Flux cored wire alloy for coatings with fair wear resistance. Suits for repair and retrofit of machinery components. Good machinability by turning. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Used for repair and upgrade of machine components, plunger, bearings, rolls.

COMPOSITION (Weight-%):

Fe	Cr	C	others
Bal.	17	0,1	<2

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	35 – 45 HRC
Melting point:	~ 1430 °C
Density:	6,7 g/dm^3
Spray rate:	4,5 kg/h / 100 A
Wire consumption:	1,0 kg/m^2 / 0,1 mm

SPRAY PROCEDURE (Arc):

	Atomizing Air Pressure	Nozzle Cap	Arc Load Volt	Ampere	Stand off mm	Coating thickness / pass mm/pass	Deposit Efficiency %
Standard 1,6 mm	3,5 bar		29-30	50-300	75-125	0,125	70-80%

SALES UNIT:

Coil	"BS 300" = 15 kg	"B 450" = 25 kg	Other dimensions on request
Wire Diameter	1,6 mm (1/16“)	2,4 mm	

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