

CORODUR[®] SP 101

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Corrosion resistant alloy in combination with very high resistance against abrasion, in particular metal on metal friction. Made exclusively for arc spraying, but may also sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Typical applied on grinding areas, pressure and conveyor screws, mixer, sieves.

COMPOSITION (Weight.-%):

Fe	Cr	Ni	B	Mo	Nb	W	C
Bal.	22	0,5	4,5	4	3,5	6,5	1,2

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	68-70 HRC
Melting point:	~ 1430 °C
Spray rate:	4,3 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		30-32	100 -200	75-125	0,125	

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	