CORODUR® SP 102

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

MATERIAL REVIEW:

Flux cored wire composition based on iron used for abrasion and erosion resistant coatings. Coatings by *CORODUR SP 102* are thermal resistant up to 650°C showing high bond strength. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Used as erosion protection coarting on water walls of boiler, cyclons, within steam turbines.

COMPOSITION (Weight.-%):

Fe	Cr	Si	B	Ti	Mn	C
Bal.	20	1,5	1,5	3,5	1,0	0,6

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	850 $HV_{0,3}$
Melting point:	~ 1430 °C
Density:	6,9 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		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	

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