CORODUR® SP 103

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 corrosion resistant coatings showing high bond strength. Coatings can be polished, and they are ductile and thermal resistant up to 870°C. Made exclusively for arc spraying, but may also sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Used as erosion protection coating on water walls of boilers, cyclons, within steam turbines.

COMPOSITION (Weight.-%):

Fe	Cr	Ni	Si	B	Mo	Mn	Cu	C
Bal.	25	10	1,2	2	4	1,2	2,0	0,5

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	45 HRC
Melting point:	~ 1210 °C
Spray rate:	2,3 kg/h / 100 A

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	70%

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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