

CORODUR[®] SP 104

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

This material produces a dense, hard, low stress abrasion coating with increasing hardness in service up to 1000 HV_{0,1}. Coatings can be polished, and they are ductile and thermal resistant up to 870°C. Material can be applied without bond coat. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Top coat for repair of components and as high effective wear protection.

COMPOSITION (Weight.-%):

Fe	Cr	Ni	Si	B	Mo	Mn	Cu	C
Bal.	21	8	1,1	2,3	3,2	1,2	2	0,2

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	53 HRC
Increasing hardness in service:	1000 HV _{0,1}
Melting point:	~ 1200 °C
Density:	6,75 g/dm ³
Spray rate:	3,4 kg/h / 100 A
Wire consumption:	1,2 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	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	