CORODUR® SP 105 HY

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

MATERIAL REVIEW:

Special alloy with a high content of Chromium and Cobalt. The coating shows austenitic structure with increasing hardness in service. Coatings are very resistant against corrosion, erosion and in particular against cavitation. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Typical applications can be found as protection coatings against cavitation and erosion in the field of water turbines, hydraulics and gas system components.

COMPOSITION (Weight.-%):

Fe	Cr	Co	Si	Mn	C
Bal.	20	11	2,8	11	0,25

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	350 HB
Increasing hardness in service:	450 HB
Melting point:	~ 1440 °C
Spray rate:	4,2 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	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	

Rev. 06-2012:2