

CORODUR[®] SP 107

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Austenitic, corrosion resistant flux cored wire alloy, with increasing hardness in service and being non-magnetic. Good machinability. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Used for repair of all kinds of machinery components.

COMPOSITION (Weight-%):

Fe	Cr	Ni	Si	Mn	C
Bal.	19	8,5	0,4	6	0,1

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	400 HB
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		29-30	50-300	125-175	0,125	80%

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	