

CORODUR[®] SP 108

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Wire alloy on iron basis resulting in corrosion resistant and very erosion resistant coatings. Coating can be polished. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Applications on water walls of boiler, paper rolls, ship shafts and in food industry.

COMPOSITION (Weight.-%):

Fe	Cr	Ni	Si	Mo	Mn	C
Bal.	26	3	1,6	0,8	1,6	1,7

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	40-42 HRC
Melting point:	~ 1260 °C
Density:	6,7 g/dm ³
Spray rate:	3,6 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		33-34	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	