

CORODUR[®] SP 112

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Abrasion and corrosion resistant coating which is easy to polish. Coatings are ductile and thermal resistant up to 870°C with low coefficient of friction with increasing hardness in service. Wire shows high deposition rate. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Excellent erosion protection on water walls and tubes of boilers. Also applied on plunger, shafts, components of chemical plants, sleeves, engine bearings, and other chrome plated parts.

COMPOSITION (Weight.-%):

Fe	Cr	Si	B	Mn	C
Bal.	27,5-29	1,5	3,8	1,5	0,1

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	1000-1150 HV _{0,1}
Melting point:	~ 1200 °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	