

## **CORODUR<sup>®</sup> SP 115**

### **Flux cored wires for Thermal Spray Application**

EN ISO 14919 – 5 – 1,6 - 4

#### **MATERIAL REVIEW:**

Flux cored wire alloy on iron basis for very wear resistant coatings under rubbing wear, having in addition high oxidation and corrosion resistance. The coatings are extremely hard; impacts should be avoided. Coatings can be polished. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

#### **APPLICATION:**

Applications for Chrome replacement on rolls for paper industry and food industry, on ship shafts and plunger.

#### **COMPOSITION (Weight-%):**

Fe	Cr	Si	Mn	C
Bal.	28	1,2	1	5

#### **PHYSICAL PROPERTIES OF THE COATING:**

Hardness:	50 - 55 HRC
Melting point:	~ 1260 °C
Density:	6,7 g/dm <sup>3</sup>
Spray rate:	3,5 kg/h / 100 A
Wire consumption:	1,2 kg/m <sup>2</sup> / 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		30-33	100-200	75-175	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	