

CORODUR[®] SP 120

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Fair resistant to corrosion but hard wire alloy having good wear resistance. Low shrinkage allows relative thick coatings. Good machinability by grinding. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Used for repair and upgrade of machine components, plunger, bearings, rolls.

COMPOSITION (Weight.-%):

Fe	Cr	Ni	Si	Mn	C
Bal.	14	0,4	0,5	0,8	0,35

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	35 – 45 HRC
Melting point:	~ 1430 °C
Density:	6,7 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	75-80%

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	