

## **CORODUR<sup>®</sup> SP 121**

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

EN ISO 14919 – 5 – 1,6 - 4

#### **MATERIAL REVIEW:**

SP 121 shows very good bonding in connection with a high deposition rate. The high Carbon content gives a extremely high hardness and abrasion resistance. For corrosion protection apply on top Zinc or Aluminum arc coatings. It can be coated either as a one layer rough coating (A) showing good bonding and very high roughness or as a two layer system with a first dense coating (B) with a top coat of high roughness as above. This results in a very good bonding and into dense coatings. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

#### **APPLICATION:**

In particular used as very rough antiskid coating on walkways in industry and on ship decks.

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

Fe	Al	Mn	C
Bal.	5,5	1	2

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

Hardness:	~ 20 HRc
Melting point:	~ 1370 °C
Density:	6,8 g/dm <sup>3</sup>
Spray rate:	4 kg/h / 100 A
Wire consumption:	0,6 kg/m <sup>2</sup> / 0,1 mm – 1,1 kg/m <sup>2</sup> / 0,1 mm

#### **SPRAY PROCEDURE (Arc):**

		Atomizing Air Pressure	Nozzle Cap	Arc Load Volt	Current Ampere	Stand off mm	Coating thickness / pass mm/pass	Deposit Efficiency %
A	Standard 1,6 mm	1 bar		27-30	200-350	100	0,5	80% - 90%
B	Standard 1,6 mm	3,5 bar		27-30	200-350	125	0,125	80% - 90%

#### **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	

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Corodur Fülldraht GmbH may change the characteristics of the wire without notice. Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. We recommend the applier to check our products for their special application autonomously.