

EN ISO 14919 - 6 - 1,6 - 4

CORODUR® SP 206

Nickel-based flux cored wire alloy of composition Ni-Cr-B-Si for application of wear resistant and corrosion resistant protective coatings. Coatings can be sintered after application (self-fluxing). Deposit reaches a hardness of 700-800 HV and features low porosity of below 2%.

Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying. Can be ground and polished to finish. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.



Used for high wear-loaded components in the chemical and food industries, Plungers.

COMPOSITION (WEIGHT-%)

Base = Ni

Cr	Si	B	W	C
20,0	4,5	1,6	2,0	0,7

Hardness HV 0,1	Melting point °C	Density gr/ dm ³	Spray rate kg/h/100 A
700-800	~ 1070	7,2	4,5

THERMAL SPRAYING

SPRAY PROCEDURE (ARC)

Standard mm	Atomizing Air Pressure	Arc Load Volt	Amperage Ampere	Stand off mm	Thickness/ pass mm/Pass	Efficiency %
1,6	3,5	30-32	100-200	75-125	0,13	70 - 80

FORMS OF DELIVERY

Coil	B5 300 = 15 kg	B 450 = 25 kg
Wire Diameter	1,6 mm (1/16")	2,4 mm (3/32")

Other Dimensions on demand