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EN ISO 14919 – 6 – 1,6 – 4

CORODUR® SP 211

Ni-Cr-B-Si with Mo and Nb cored wire to apply wear resistant and corrosion resistant protective coatings with good resistance to chloride attack in boiler atmospheres. Coating may harden up to 1000 HV. Applications up to 450°C (surface temperature). Porosity of below 2% can be achieved. Made exclusively for arc spraying but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

Main application on water walls and tubes of boiler.

THERMAL SPRAYING

COMPOSITION (WEIGHT-%)

Base = Ni

Cr	Si	B	Mo	Nb	Fe
20,0	4,0	4,0	6,0	3,0	<2,0

Hardness HV 0,1	Melting point °C	Density gr/ dm³	Spray rate kg/h/100 A
800 -1000	~ 1150	7,3	5,0

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

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FORMS OF DELIVERY

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

Other Dimensions on demand