

EN ISO 14919 - 6 - 1,6 - 4

CORODUR® SP 233

Ni-Al- cored wire featuring very high bond strength, also on smooth surfaces. Self-bonding due to exothermic reaction. Coating is very dense and can be applied on clean but not sand blasted surfaces. Best bonding if applied in one

pass (about 0,125 mm). Coating is easy to machine. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.



Bond coat featuring excellent resistance to oxidation and high temperatures up to 650 °C.

COMPOSITION (WEIGHT-%)

Base = Ni

Al

10,0

Hardness
HV

65

Melting point
°C

~ 1430

Density
gr/ dm³

7,8

Spray rate
kg/h/100 A

4,5

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	29 -32	200-300	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

THERMAL SPRAYING

Rev. 01.01-2021.1