

CORODUR[®] SP 106

Flux cored wires for Thermal Spray Application

EN ISO 14919 – 5 – 1,6 - 4

MATERIAL REVIEW:

Wire for thermal spray composed from tungsten carbide and titanium carbide within an amorphous matrix. The coating shows very good resistance against abrasion having high bond strength and good deposition rate. Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.

APPLICATION:

Used as coatings to prevent sliding on industrial paths and on deck of ship.

COMPOSITION (Weight-%):

Fe	Cr	Ni	Si	Mn	WC	B	Ti ₂ C ₃
Bal.	14	4,5	1,3	0,6	26	1,9	6

PHYSICAL PROPERTIES OF THE COATING:

Hardness:	64-69 HRc
Melting point:	~ 1200 °C
Density:	6,75 g/dm ³
Spray rate:	2,9 kg/h / 100 A
Wire consumption:	1,2 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	4,1 bar		30-32	100-200	75-125	0,125	70%

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	