

**Atomized Aluminum-Silicon Powder Suitable for use with Thermal Spray
Combustion Equipment**

AluTec® 29210



COATING

- Ideal for corrosion control on steel structures, duct-work and pipes
- For use with TeroDyn System 2000 and 3000
- May be used for dimensional restoration of aluminum and magnesium parts



DESCRIPTION:

AluTec 29210 is an atomized Aluminum - Silicon alloy powder suitable for coating application using combustion thermal spray equipment such as the TeroDyn®2000 or TeroDyn 3000 Systems. It can be used for corrosion control on steel structures and duct work and pipes. It can be used instead of 29220 where a machined finish and higher hardness are desired for dimensional restoration of aluminum and magnesium parts. 29210 is not self bonding. It requires an SSPC 5 blast finish using an angular aluminum oxide or chilled iron grit. A 24 to 40 grit size is usually capable of producing the 1 - 3 mil blast profile which is required for good mechanical bonding to the base material (a nickel alloy bond coat could be used if desired). Avoid use in strong Acids or Caustics. For best results seal coating with SealTec®-LT or RotoGuard® Solution.

TYPICAL APPLICATIONS:

- Shafts
- Casings
- Pumps
- Blower housings

RECOMMENDED COATING AND SPRAY PARAMETERS:

TD 2000	Acetylene Fuel
Nozzle	LT 250
LT Air Shroud	5 psi
Module Adaptor	Red/Yellow
Oxygen	50 psi / 28 flow
Acetylene	12 psi / 48 flow
T-Valve Setting	6 clicks
Coating Rate	5 lbs/hr
Spray Distance	7-9 inches

TD 2000	Propylene Fuel
Nozzle	LT 260P
LT Air Shroud	30 psi
Module Adaptor	Red/Yellow
Oxygen	80 psi / 48 flow
Propylene*	30 psi / 48 flow
T-Valve Setting	10 clicks
Coating Rate	8 lbs/hr
Spray Distance	8-10 inches

* Use Linde grade FG-2 or equivalent

TD 3000	
Nozzle	LR 210W
Rotojet	RPA-3@ 50 psi
Oxygen	50 psi / 34 flow
Acetylene	12 psi / 54 flow
Carrier Gas (Ar or Nit.)	55 psi / 40 flow
Terometer**	100
Coating Rate	15 lbs/hr
Air Vibrator	20 psi
Spray Distance	6-8 inches

**Use slotted pick-up tube and a 12 foot black powder feed hose.

TECHNICAL DATA:

Powder Properties

Nominal Particle Size: -106 micron +45 micron
Hall Flow Rate: 60 seconds
Bulk Density: 1.4 g/cc
Powder Coverage: 0.015 lbs/ft² @ 0.001 inch thickness

Coating Properties

Typical Hardness: Rockwell RH 90
Maximum Service Temperature: 750°F (405°C)
Thickness Limit: 0.125"
Density: 2.3 g/cc
Approximate Melting Point: 1060°F (573°C)

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