

Austenitic Stainless Powder for Plasma Transferred Arc Application

EuTroLoy[®] 16300 LC



COATING

- CONFORMS TO A.I.S.I. 316L
- MACHINABLE WITH CONVENTIONAL TOOLING
- EXCELLENT CORROSION RESISTANCE
- USE AS BUFFER LAYER OR TOP COATING
- LOW COEFFICIENT OF FRICTION
- EXCELLENT HIGH TEMPERATURE SCALING RESISTANCE



DESCRIPTION:

Eutroloy 16300LC is a Type 316L stainless steel designed for application via the plasma transferred arc welding process. The coatings produced are moderately soft and can be machined with conventional tooling. Eutroloy 16300LC can be used as a buttering layer for subsequent overlay with a harder, more wear resistant top coat or it can be used as a final coating for applications requiring resistance to corrosion.

Type 316L stainless steel deposits will exhibit excellent resistance to general corrosion, pitting, crevice corrosion and stress corrosion cracking. In addition, coating of Eutroloy 16300LC will exhibit excellent resistance to scaling up to the maximum service temperature.

TECHNICAL DATA:

POWDER PROPERTIES:

Composition: C, Si, Cr, Ni, Mo, Mn, Fe Bal.
Melting Point Range : 2510 – 2550° F (1375 – 1400° C)

COATING PROPERTIES:

Macro hardness: HRB 80
Micro hardness: Vickers 160
Density: 8.0 g/cc (0.289 lb/in³)
Max Service Temperature: 1700°F (925°C)
Coefficient of Thermal Expansion: 9.0 X 10⁻⁶ in/in/F
Machinability: Use Conventional Carbide Toolin
Note: Deposit will work harden

PROCEDURE FOR USE:

For some applications a modest pre-heat may be required. The degree is dependent on the shape and dimensions of the part and the thickness of the deposit. Please contact Eutectic Technical Services for more information.

EQUIPMENT:

Made for use in Eutectic's GAP plasma transferred arc equipment. Please contact Eutectic to determine which GAP equipment is right for your coating needs.

APPLICATIONS:

- Machine Element Repair
- Mis-machined Parts
- Pump Parts
- Seal Rings
- Screw Flights

Typical Industries

- Utilities
- Chemical Processing
- Marine
- Waste Management
- Pulp & Paper

HEALTH & SAFETY:

Observe normal spraying practices, respiratory protection and proper air flow pattern advised. For general spray practices, see AWS Publications AWS C2. 1-73, "Recommended Safe Practices for Thermal Spraying and AWS TSS-85, "Thermal Spraying, Practice, Theory and Application." Thermal spraying is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before starting spray operations. DO NOT operate your spraying equipment or use the spray material supplied, before you have thoroughly read the equipment instruction manual. Refer to the Eutectic web site for Material Safety Data Sheet (MSDS) information.

DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH



Eutectic Castolin develops and manufactures PTA welding units and accessories in various models and sizes either as standard units or as special developments. Our team of technicians will be able to design with you the cost effective and tailor made solution that fits your specific application. From power source to feed unit, welding torch, even handling devices or robots when required, we take care of all the details.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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