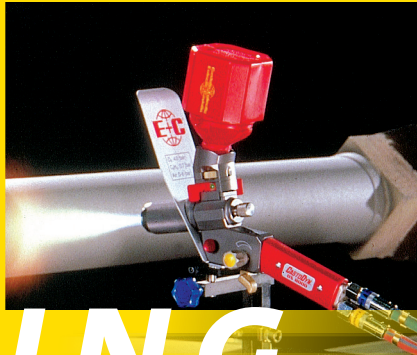


Atomized Martensitic Stainless Steel Alloy Powder

Eutectic® 19400



COATING

- Two-step “Cold Process” powder
- Excellent resistance to abrasive wear and mechanical shock
- Precise particle sizing ensures coating consistency
- Suitable for metal-to-metal wear applications



DESCRIPTION:

Eutectic 19400 is a water atomized martensitic stainless steel alloy powder designed for use with the TeroDyn® Systems 2000 or 3000 and the RotoTec® torches. It is a two-step “Cold Process” powder which must be used in conjunction with a bond coat powder such as UltraBond 50000 or ProXon 21021 or ProXon 21031. Precise control of particle size and chemistry ensure that coatings will offer excellent resistance to abrasive wear and wear due to mechanical shock.

TECHNICAL DATA:

Coating Properties:

Typical macro-hardness: Rockwell C Scale, 35
Typical density: 7.0 g/cc
Thickness limit: 0.100 inch
Max. service temperature: 1,000°F (538°C)

Powder Properties:

Hall flow rate: 29 seconds
Bulk density: 2.7 g/cc
Powder coverage: 0.040 lbs/ft² @ 0.001”

RECOMMENDED COATING AND SPRAY PARAMETERS:

**** Requires a Bond Coat of UltraBond 50000 ****

TD 2000	
Nozzle	RL 200
RotoJet	RPA-3@ 30 psi air
Module Adaptor	Yellow/Red
Oxygen	50 psi / 35 flow (FM-1 flowmeter)
Acetylene	12 psi / 75 flow (FM-1 flowmeter)
T-Valve Setting	18 clicks
Coating Rate	16 lbs/hr
Spray Distance	7-8 inches

TD 3000	
Nozzle	RL 210W (or 3310)
RotoJet	RPA-3@25 psi air
Oxygen	50 psi / 38 flow
Acetylene	12 psi / 60 flow
Terometer	125
Coating Rate	20 lbs/hr
Spray Distance	8-12 inches
Carrier Gas	Nitrogen @ 55psi / 37 flow
Air Vibrator	20 psi

PROCEDURE FOR USE:

Grind finish only (do not use coolant unless coating is sealed)

Wheel Specification: 11 C 80 F 13 V Pmf (for 16” wheel)

Wheel Speed: 5000 - 6000 RPM

Cross Feed

Roughing: 75% of the wheel width per revolution of work piece.

Finishing: 12.5% of the wheel width per revolution of work piece.

In-Feed

Roughing: generally less than 0.005”; operator experience should guide this operation.

Finishing: should never exceed 0.001 to 0.002 inch.

Coolant: Coating should be sealed so that coolant can be used.

TYPICAL APPLICATIONS:

- Pistons
- Bell housings
- Pump parts
- Wear rings
- Cylinder liners
- Rolls

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