

Gas Atomized, Nickel Alloy Powder for the Plasma Transferred Arc (PTA) Process

EuTroLoy[®] 16112



COATING

- Specially developed for the plasma transferred arc process
- Excellent resistance to abrasion, friction and erosion
- Excellent for use on steels, stainless steels, cast irons and nickel-base alloys.



DESCRIPTION:

EuTroloy 16112 is a high performance powder containing a blend of 60% cast and crushed tungsten carbide plus NiBSi alloy powder. Coatings are resistant to abrasion and erosion and can tolerate mild levels of impact. The coatings can be put in service as-deposited or finished by grinding and polishing.

TECHNICAL DATA:

Hardness: 54 HRC

Density: 10.0 g/cc

Maximum Service Temperature: 1200°F (649°C)

ASTM G-65 Wear Test Volume Loss: 13 mm³

Hall Flow Rate: 12 seconds

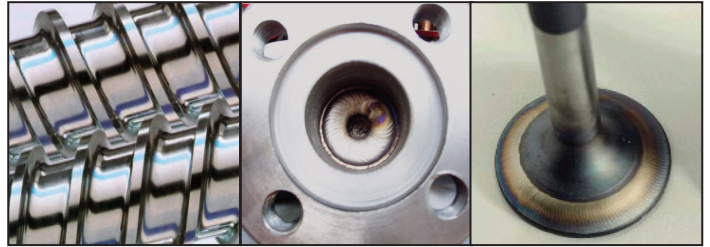
Bulk Density: 5.5 g/cc

APPLICATIONS:

- Mixer Paddles & Blades
- Screw Flights
- Drilling Equipment
- Brick and Tile Extrusion
- Auger Points
- Conveyor Chains
- Coal Feeder Screws
- Plow Discs and Harrows

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.



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.

FINISHING PROCEDURE:

Grinding Wheel Type:	Green Silicon Carbide (For roughing)	Aluminum Oxide (For finishing)	Diamond D151 (FEPA std)
Grit Size:	60 - 120	120 or finer Concentration	75
Grade:	I - L	I - L	-----
Structure:	5 - 6 - 7	7 - 8 - 9	-----
Bond Type:	Vitrified	Vitrified	Metal
Wheel Speed:	6500 ft per minute	6500 ft per minute	18 - 22 meter/min
In-Feed:	Roughing: 0.001 inches per pass Finishing: 0.0005 inches per pass or less		
Coolant:	Flood coolant with rust inhibitors in 2-5% concentration		

Notes: 1. Before grinding, all edges and ends of coating must be chamfer ground.
2. Frequently dress the grinding wheel face to reduce friction and heat.

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

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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