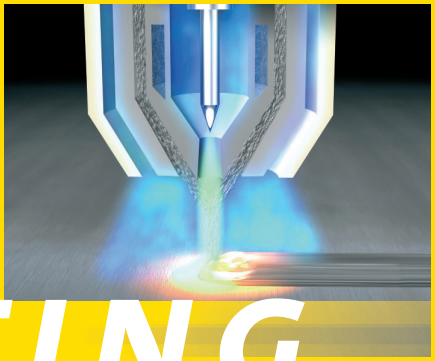
Gas Atomized, Nickel Alloy Powder for the Plasma Transferred Arc (PTA)Process

EuTroLoy® 16496A



COATING

- Specially developed for the plasma transferred arc process
- Spherically shaped to ensure highest purity
- Consistant powder distribution through equipment
- Abrasion and friction resistant coatings
- Reduced tendency for nozzle/shield cup loading

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

EuTroloy 16496A is a high performance atomized nickel alloy powder optimized to produce hard, durable, abrasion, and friction resistant coatings using the Eutronic® GAP Plasma Transferred Arc Welding Process. Controlled composition based on AWS A5.13 and precise particle sizing ensures consistent, porosity free weld deposition.

EuTroloy 16496A powder has a unique particle shape which reduces the tendency for nozzle/shield cup loading.

TECHNICAL DATA:

Hardness: Rockwell C scale: 59
Density: 7.8 g/cc
Maximum Service Temperature: 1000°F (538°C)
ASTM G-65 Wear Test Volume Loss: 28 mm^3
Hall Flow Rate: 17 seconds
Bulk Density: 4 g/cc

PROCEDURE FOR FINISHING:

Grinding Wheel Type: Green Silicon Carbide
Grit Size: 60 - 80
Grade: H (soft)
Structure: 5
Bond Type: Vitrified
Wheel Speed: Use Manufacturer's Recommendation
Work Speed: 50 -65 surface feet per minute
Traverse Speed
  Roughing: 5-15 inches per minute
  Finishing: 3-8 inches per minute
In-Feed
  Roughing: 0.001 inches per pass
  Finishing: 0.0005 inches per pass or less
Use 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.

APPLICATIONS:

- Shafts
- Extrususion screws
- Sleeves
- Rotors

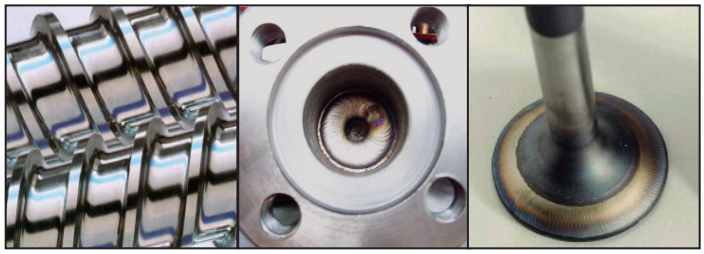
EQUIPMENT:

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.

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

Castolin Eutectic®
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