

Copper Alloy Designed for the Eutalloy Process

# Eutalloy® 10146



## COATING

- Excellent machinability
- Very good corrosion resistance
- Low coefficient of friction



## DESCRIPTION:

Eutectic 10146 is a copper-tin Eutalloy alloy for build-up and joining of copper-base alloys. Coatings of 10146 provide an excellent combination of machinability and corrosion resistance.

## APPLICATIONS:

Shafts  
Gears  
Gauges  
Slideways  
Beds  
Molds  
Keyways

## TECHNICAL DATA:

### Powder Properties

Hall Flow Rate: 13 seconds  
Bulk Density: 5 g/cc

### Coating Properties

Typical Hardness: HRB 28  
Machinability: Excellent  
Corrosion Resistance: Good  
Maximum Service Temperature: 700°F (371°C)  
Deposit Limit: Unlimited  
Gases: Oxygen and Acetylene  
Torches: Eutalloy B and SuperJet-S

## PROCEDURE FOR USE:

### Preparation:

All surfaces to be coated should be thoroughly cleaned, removing all contaminants, oxides and grease. Thin surfaces and edges require no preheating. However, large, heavy and cast iron parts of all thickness should be heated to about 575°F (approx. 302°C) (blue hot).

### Coating instructions:

For coating operations the flame of the Eutalloy B or SuperJet S torch should be adjusted to neutral with the powder feed on. To prevent oxidation of the base material we recommend spraying a thin coat of Eutalloy 10224. A second coat is delivered in the following manner: preheat locally to fusion point (when the first coat becomes glazed in appearance), then spray and fuse the second coat simultaneously. Move progressively along, spraying and fusing, until the entire surface is covered. Distance between the cone of the flame and the piece should be .25 - .75 inch. Leave the part to cool slowly and away from air currents. Where possible, place it in vermiculite or cover with a thermal blanket

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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