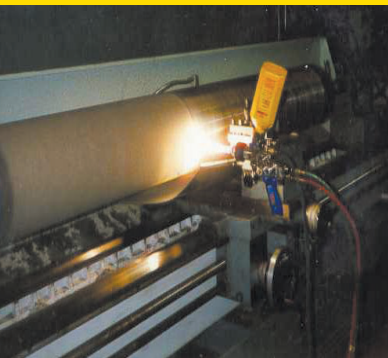


Nickel-Base Alloy Designed for the Eutalloy Process

Eutalloy® 10185



COATING

- Excellent resistance to wear and corrosion
- Excellent weldability and machinability on a wide range of steels and stainless steels
- Thin, tough overlays maintain tight dimensional tolerances



DESCRIPTION:

Eutectic 10185 is a nickel base Eutalloy alloy designed to provide a combination of machinability and resistance to wear and corrosion. Excellent weldability and machinability permits easy contour forming on steels, stainless steel, nickel alloys and cast irons. The Eutalloy process permits precise deposition of 10185 so that thin, tough overlays can be applied and dimensional tolerances maintained.

APPLICATIONS:

Bearing Surfaces	Moulds
Crankshaft Journals	Pump Parts
Dies	Shafts
Diesel Valves	Tile Dies
Feed Rolls	Valve Plugs
Material Pins	Valve Seats
Glass Mould Plungers	

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.

TECHNICAL DATA:

Powder Properties

Nominal Composition: Nickel, Balance Boron, Silicon
Hall Flow Rate: 14 seconds
Bulk Density: 4.8 g/cc
Approximate Melting Range: Solidus, 1775°F (968°C)
Liquidus, 2100°F (1149°C)
Furnace Fusing: 2125°F (1163°C) (suggested set point)

Coating Properties

Typical Hardness: HRC 39
Maximum Service Temperature: 900 - 1400°F (483-760°C)
Thickness Limit: 0.25", or more

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



EUTECTIC CORPORATION
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
Tel.: +1 (800) 558-8524
eutectic.com

EUTECTIC CANADA
428, rue Aimé-Vincent
Vaudreuil-Dorion, Québec
J7V 5V5 Canada
Tel.: +1 (800) 361-9439
eutectic.ca



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