

Nickel-Based Alloy Recommended for Cast Iron Protection and Repair

Eutalloy® 10224



COATING

- Ideal for protective coating, joining and cladding applications
- The deposit is easy to machine with standard cutting tools
- Exceptionally heat resistant
- Ideal for protection against metal-to-metal friction



DESCRIPTION:

Eutalloy 10224 (NiTec) is a nickel-based alloy with properties which make it ideal for protective coating, joining and cladding applications on a variety of base metals including steels, cast irons and nickel alloys. The deposit is easy to machine, with standard cutting tools, and has a low coefficient of friction and wear resistance properties which make it ideal for protection against metal-to-metal friction. It is also exceptionally heat resistant.

Eutalloy 10224 is manufactured by a process of atomization, designed to ensure both optimum spheroidization and controlled granulometry. This in turn ensures trouble-free fusion of the alloy using our SuperJet Eutalloy torch. Eutalloy 10224, applied with a Eutalloy system, produces smooth and uniform quality coatings.

This maintenance-engineered coating technology increases the value and reliability of parts treated, with results far superior to conventional repair processes, and savings in costs including those of machining.

Eutalloy 10224 is recommended for rectifying both machining and casting defects, as well as for protective coatings against oxidation, with a considerable gain in service life for a number of parts.

TECHNICAL DATA:

Typical Hardness (HRb): 90

Melting range (sol./liq.) (°F): 1920°-2330°
(approx. 1049°-1277° C)

Density (lb./in³): 0.293

Heat-stability (°F): 1112° (600°C)

Metal-to-metal friction property: Excellent

Corrosion resistance: Very good

Machinability: Excellent, with normal cutting tools

Base materials: For steels, cast irons and nickel alloys

Gases: Oxygen-acetylene

Torches: Eutalloy B and SuperJet S

APPLICATIONS:

Recommended for corrosion/wear-resistant coatings on journals and gearwheels, exhaust manifolds, etc., for repair of casting and machining defects and for repair of worn areas of deep-drawing dies.

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

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