

Nickel-Based Alloy Recommended as a Build-up on Cast Iron Parts

Eutalloy® 11490



COATING

- Ideal for protective coating, joining and cladding applications
- The deposit is easy to machine with standard cutting tools
- Exceptionally heat resistant
- Excellent machineability



DESCRIPTION:

11490 is a nickel base alloy powder designed to provide easy build-up on cast iron parts and excellent machinability. Machined deposits are bright and porosity free. The hardness of this alloy promotes good edge integrity while not detracting from its machinability. The high compressive strength of this alloy resists deformation at elevated temperatures. The Eutalloy process permits precise deposition of 11490 so that thin, tough overlays can be applied and dimensional tolerances maintained.

TECHNICAL DATA:

Powder Properties

Nominal Composition: Nickel, Balance, Boron, Silicon
Hall Flow Rate: 14 seconds
Bulk Density: 4.8 g/cc

Coating Properties

Typical Hardness: HRB 95
Maximum Service Temperature: 1200°F (649°C)
Thickness Limit: Unlimited

APPLICATIONS:

General-purpose build-up and dimensional restoration for cast iron and steel parts such as:

- Gears
- Shafts
- Patterns
- Clutches
- Templates

PROCEDURE FOR USE:

Finishing Procedure:

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
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.

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