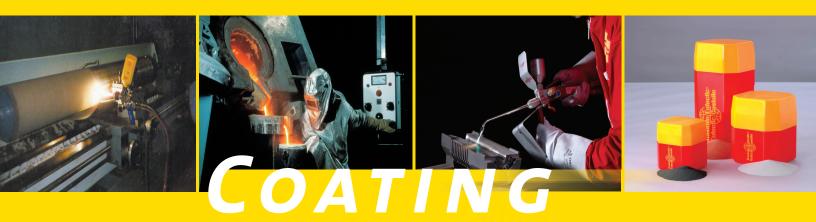
Nickel-Based Alloy Designed to Provide a Combination of Machinability and Resistance to Wear and Corrosion

Eutalloy 11493



- Easy contour forming on stainless steels, steels, nickel and cast iron
- The deposit is easy to machine with standard cutting tools
- Exceptionally heat resistant
- Excellent machineability



DESCRIPTION:

Eutectic 11493 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 11493 so that thin, tough overlays can be applied and dimensional tolerances

TECHNICAL DATA:

Powder Properties

Nominal Composition: Nickel, Boron, Silicon

Hall Flow Rate: 14 seconds Bulk Density: 4.8 q/cc

Approx. Melting Range: Solidus., 1775° F (968°C)

Liquidus, 2100°F (1150°C)

Furnace Fusing, 2125° F (1163°C) (suggested)

Coating Properties

Typical Hardness: HRC 39

Maximum Service Temperature: 900 - 1400°F (482-760°C)

Thickness Limit: 0.25", or more

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.

APPLICATIONS:

Bearing surfaces

• Pump parts

Crankshaft journalsDies

ShaftsTile dies

• Diesel valves

Valve pluqs

Feed rolls

Valve Seats

Material pins

Valve SeatsWear rings

Moulds

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