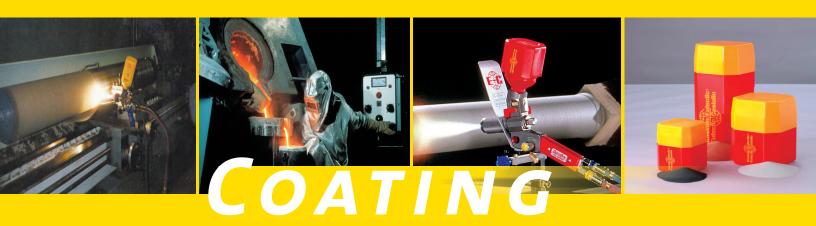
Nickel-Copper Alloy Designed for Re-Building Steels, Stainless Steels, Nickel and Wrought or Cast Monel

Eutalloy 11494



- Excellent corrosion resistance
- Excellent weldability
- Good machinability



DESCRIPTION:

11494 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 11494 so that thin, tough overlays can be applied and dimensional tolerances maintained.

TECHNICAL DATA:

Powder Properties

Nominal Composition: Ni, Cr, Si, B Hall Flow Rate: 15 seconds

Bulk Density: 4.5 q/cc

Approx. Melting Range: Solidus., 1780° F (971°C) Liquidus, 2120°F (1160°C)

Furnace Fusing, 2150° F (1177°C) (suggested)

Coating Properties

Hardness: Rockwell C scale: 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 Shafts

 Crankshaft journals Dies

Tile dies

Diesel valves

Valve pluas

 Feed rolls Material pins

 Valve Seats Wear rings

Molds

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