

Nickel-Based, Self-Fluxing, Hardfacing Powder for Resistance to Impact and Wear

Eutalloy® 11497



COATING

- Porosity-free deposits
- Hand-finishing capability
- Rapid build up with minimal overspray
- Excellent machinability



DESCRIPTION:

Eutectic 11497 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 11497 so that thin, tough overlays can be applied and dimensional tolerances maintained.

TECHNICAL DATA:

Powder Properties

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

Coating Properties

Hardness: 25 HRC
Maximum Service Temperature: 1200°F (650°C)
Thickness Limit: Unlimited

APPLICATIONS:

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

- Gears
- Cast Iron valve seats
- Molds
- Keyways
- Bearing seats
- Renew drawing tools

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 5 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 Eutectic 11497. 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

Finishing Procedure:

Machine with standard carbide tools or grind with the following parameters:

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

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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