



Atomized Aluminum-Silicon Powder
Suitable for use with Thermal Spray
Combustion Equipment

AluTec® 29210



- Ideal for corrosion control on steel structures, duct-work and pipes
- For use with TeroDyn System 2000 and 3000
- May be used for dimensional restoration of aluminum and magnesium parts

AluTec® 29210

AluTec 29210 is an atomized Aluminum-Silicon alloy powder suitable for coating application using combustion thermal spray equipment such as the TeroDyn® 2000 or TeroDyn 3000 Systems. It can be used for corrosion control on steel structures, duct work and pipes. It can be used instead of 29220 where a machined finish and higher hardness are desired for dimensional restoration of aluminum and magnesium parts.

29210 is not self bonding. It requires an SSPC 5 blast finish using an angular aluminum oxide or chilled iron grit. A 24 to 40 grit size is usually capable of producing the 1 - 3 mil blast profile which is required for good mechanical bonding to the base material (a nickel alloy bond coat could be used if desired). Avoid use in strong Acids or Caustics. For best results seal coating with SealTec®-LT or RotoGuard® Solution.

TECHNICAL DATA

Typical Powder Properties	
Nominal Particle Size:	-106 micron +45 micron
Hall Flow Rate:	60 seconds
Bulk Density:	1.4 g/cc
Powder Coverage:	0.015 lbs/ft² @ 0.001"
Typical Coating Properties	
Hardness:	Rockwell RH 90
Max. Service Temperature:	750°F (405°C)
Thickness Limit:	0.125"
Density:	2.3 g/cc
Approximate Melting Point:	1060°F (573°C)

PROCEDURE FOR USE

TD 2000 (Acetylene Fuel)

Nozzle:	LT 250
LT Air Shroud:	5 psi
Module Adaptor:	Red/Yellow
Oxygen:	50 psi / 28 flow
Acetylene:	12 psi / 48 flow
Spray Rate:	5 lb/hr
Spray Distance:	7 to 9 inches
T-Valve	6 clicks

TD 2000 (Propylene Fuel)

Nozzle:	LT 260P
LT Air Shroud:	30 psi
Module Adaptor:	Red/Yellow
Oxygen:	80 psi / 48 flow
Propylene*:	30 psi / 48 flow
Spray Rate:	8 lb/hr
Spray Distance:	8 to 10 inches
T-Valve	10 clicks

* Use Linde grade FG-2 or equivalent.

TD 3000

Nozzle:	LR 210W
Rotojet:	RPA 3 @ 50 psi
Oxygen:	50 psi / 34 flow
Acetylene:	12 psi / 54 flow
Carrier Gas:	Ar or Nit. @ 55 psi / 40 flow
Terometer**:	100
Spray Rate:	15 lb/hr
Air Vibrator:	20 psi
Spray Distance:	6 to 8 inches

** Use slotted pick-up tube and a 12 foot black powder feed hose

TYPICAL APPLICATIONS

- Shafts
- Casings
- Pumps
- Blower Housings

Observe normal spraying practices, respiratory protection and proper air flow pattern advised. For general spray practices, see AWS Publications AWS C2.1-73, "Recommended Safe Practices for Thermal Spraying and AWS TSS-85, "Thermal Spraying, Practice, Theory and Application." Thermal spraying is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before starting spray operations. DO NOT operate your spraying equipment or use the spray material supplied, before you have thoroughly read the equipment instruction manual. Refer to the Eutectic website for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH.



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