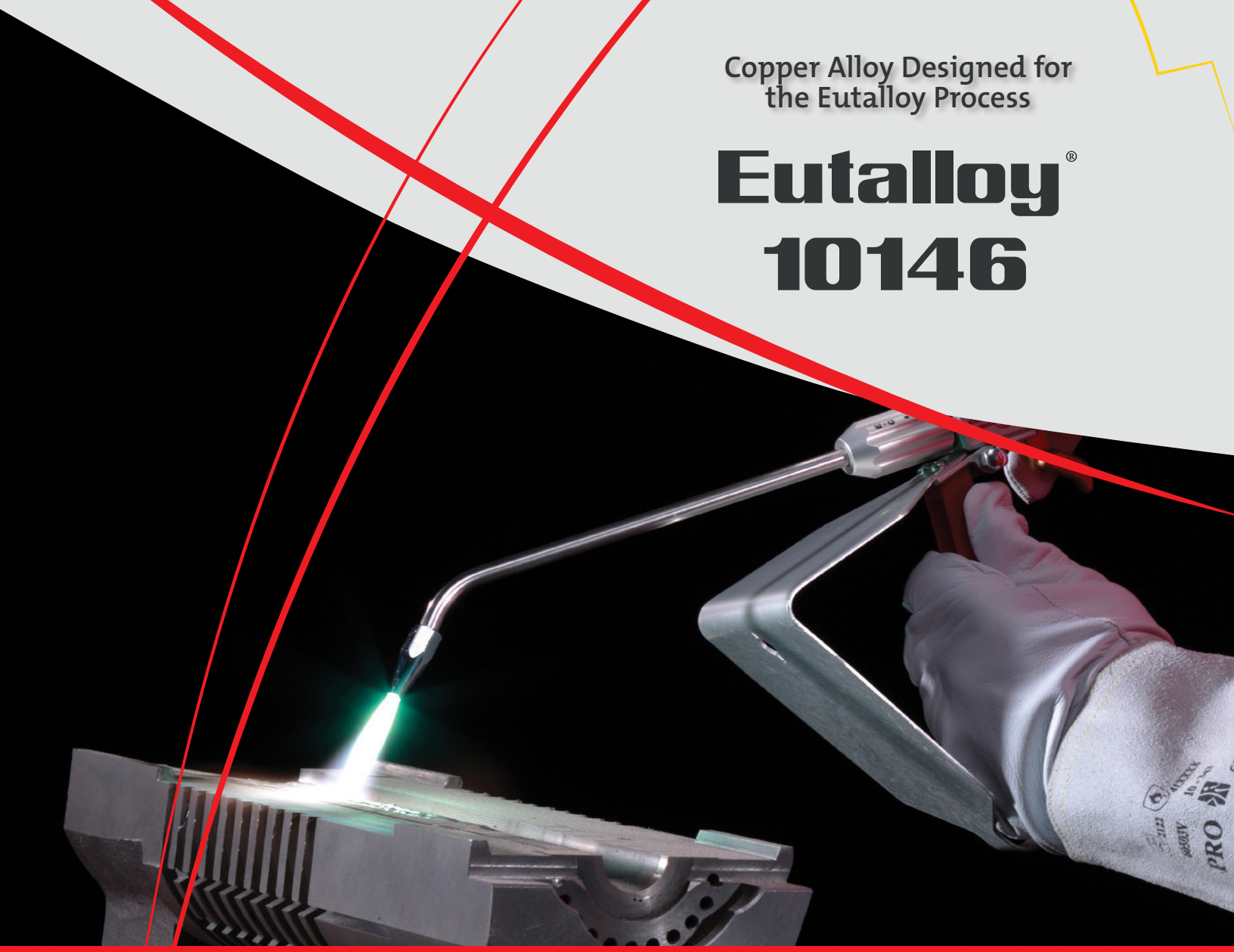
Castolin Eutectic®
Eutectic Castolin

Copper Alloy Designed for the Eutalloy Process

Eutalloy® 10146



- Excellent machinability
- Very good corrosion resistance
- Low coefficient of friction

Eutalloy® 10146

Eutectic 10146 is a copper-tin Eutalloy alloy for build-up and joining of copper-base alloys. Coatings of 10146 provide an excellent combination of machinability and corrosion resitance.

TECHNICAL DATA

Typical Powder Properties	
Hall Flow Rate:	13 seconds
Bulk Density:	5 g/cc
Typical Coating Properites	
Hardness:	HRB 28
Machinability:	Excellent
Corrosion Resistance:	Good
Maximum Service Temperature:	700°F (371°C)
Deposit Limit:	None
Gases:	Oxygen and Acetylene
Torch:	SuperJet-S

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-S 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 Eutalloy 10224. 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.

TYPICAL APPLICATIONS

- Shafts
- Gauges
- Beds
- Keyways
- Gears
- Slideways
- Molds

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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05-2022