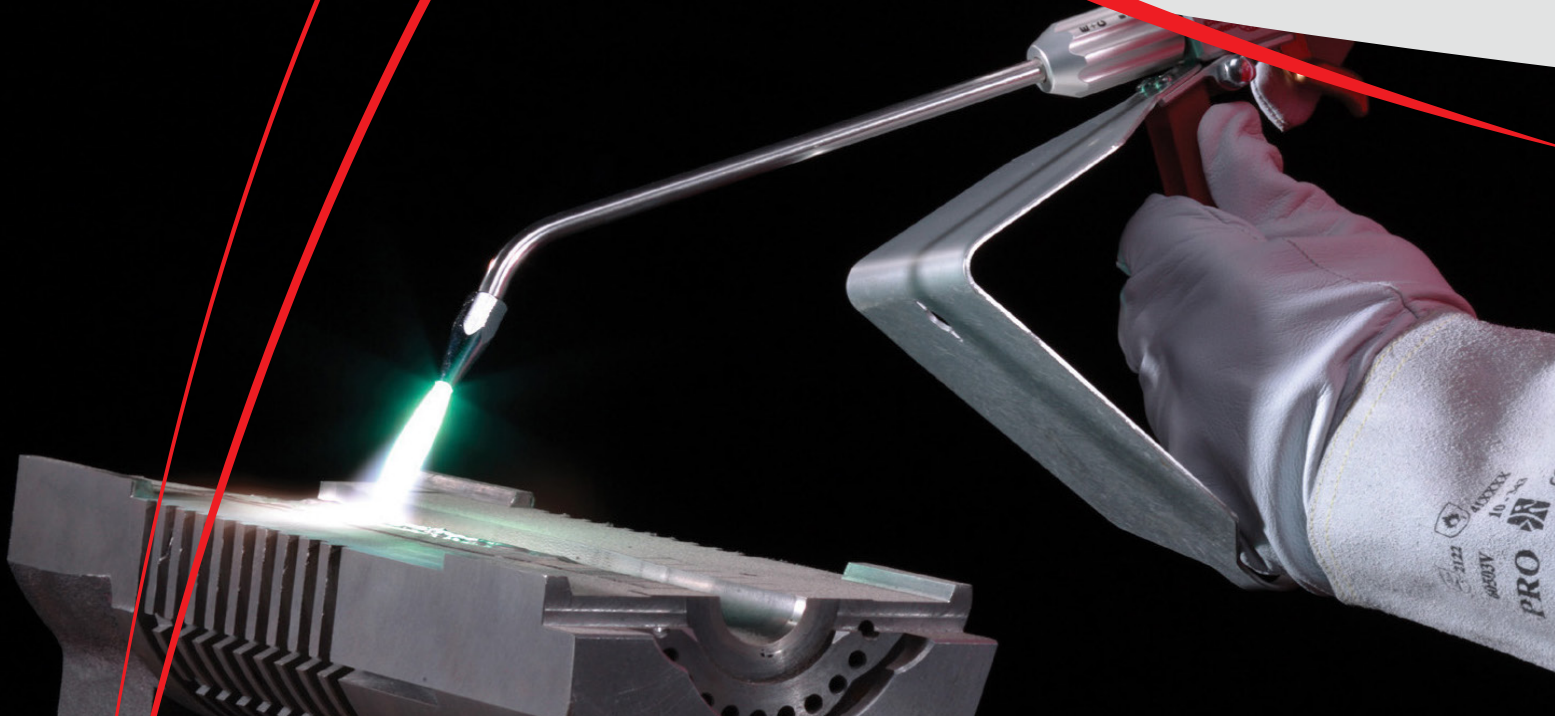




Atomized Nickel-Based Alloy Designed
for Glass Mold Applications

Eutalloy® **1202**



- Reduced overspray
- Excellent build-up capability
- Machinable with hand finishing techniques
- Well suited for mold edge and corner repair

Eutalloy® 1202

Eutectic 1202 is an atomized nickel-based powder designed for use on typical glass mold parts. The method of application is via the one-step spray/fuse process and the use of the Eutalloy® SuperJet-S® torch system.

Eutectic 1202 is the optimum choice for re-working the corners and edges of blanking molds and finishing molds. The deposits are relatively soft and can be finished using conventional hand techniques. Of particular advantage is the virtual absence of overspray. Multiple layers of Eutectic 1202 can be applied without gassing or porosity and the as-deposited coating is clean, smooth and free from borosilicate islands.

TECHNICAL DATA

Typical Powder Properties

Melting Range:	Solidus: 1780°F (971°C) Liquidus: 2120°F (1160°C) Fusing: 2150°F (1177°C)
Hall Flow Rate:	13 seconds / 50 grams
Bulk Density:	5.0 g/cc
Nominal Composition:	Si + B + Ni

Typical Coating Properties

Hardness:	HRC 21
Density:	8.6 g/cc (0.0310 lb/in ³)
Coverage:	0.045 lb/ft ² @ 0.001"
Shrinkage:	15% - 20%

PROCEDURE FOR USE

TD 2000

Nozzle:	RL 200 RPA 3 @ 20 psi air Yellow/Red
Module Adaptor:	Yellow/Red
Oxygen:	50 psi / 35 flow (FM-1 flowmeter)
Acetylene:	12 psi / 75 flow (FM-1 flowmeter)
T-Valve Setting:	14-16 clicks
Coating Rate:	18 lb/hr
Spray Distance:	6 to 7 inches

TD 3000

Nozzle:	RL 200W RPA 3 @ 20 psi air
Oxygen:	50 psi / 32 flow
Acetylene:	12 psi / 48 flow
Carrier Gas:	(Ar or N ₂) 55 psi / 37 flow
Terometer:	130 (adjust to achieve spray rate)
Coating Rate:	20 lb/hr
Spray Distance:	6 to 8 inches
Deposit Efficiency:	90%

TYPICAL APPLICATIONS

- Mold Edges and Mold Corners
- Ring Discs
- Mold Necks
- Bases
- Bottoms

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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