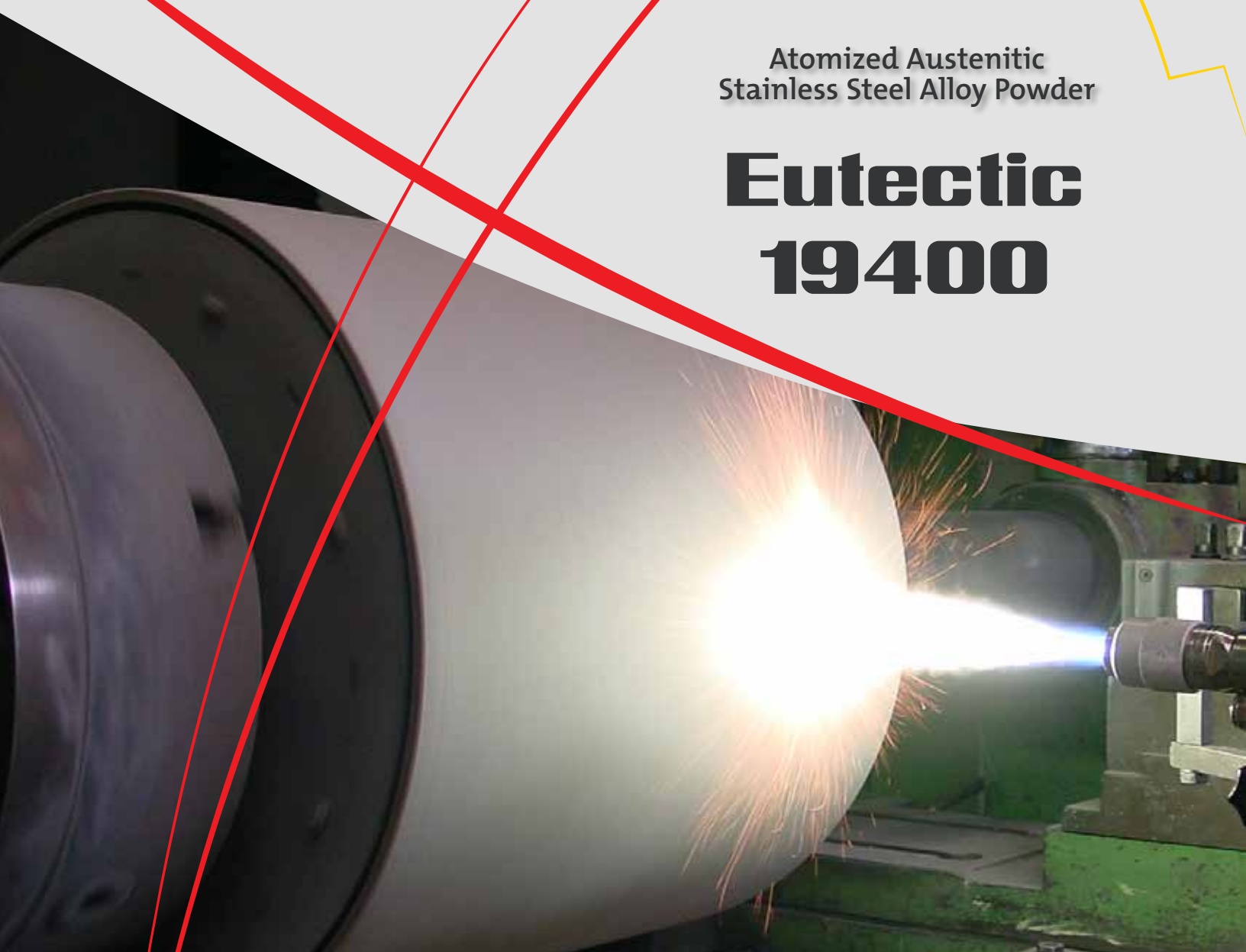




Atomized Austenitic
Stainless Steel Alloy Powder

Eutectic 19400



- Two-step “Cold Process” powder
- Excellent resistance to abrasive wear and mechanical shock
- Precise particle sizing ensures coating consistency
- Suitable for metal-to-metal wear applications

Eutectic 19400

Eutectic 19400 is a water atomized martensitic stainless steel alloy powder designed for use with the TeroDyn® Systems 2000 or 3000 and the RotoTec® torches. It is a two-step "Cold Process" powder which must be used in conjunction with a bond coat powder such as UltraBond 50000, ProXon 21021 or ProXon 21031. Precise control of particle size and chemistry ensure that coatings will offer excellent resistance to abrasive wear and wear due to mechanical shock.

TECHNICAL DATA

Typical Values	
Typical Macrohardness:	35 HRC
Coating Density:	7.0 g/cc
Thickness Limit:	0.100 inch
Max. Service Temperature:	1000°F (538°C)
Hall Flow Rate:	29 seconds
Bulk Density:	2.7 g/cc
Powder Coverage:	0.040 lb/ft ² @ 0.001"

PROCEDURE FOR USE:

Grin finish only - DO NOT use coolant unless coating is sealed

Wheel Specification: 11 C 80 F 13 V Pmf (for 16" wheel)

Wheel Speed: 5000 - 6000 RPM

Cross Feed: Roughing: 75% of the wheel width per revolution of work piece
Finishing: 12.5% of the wheel width per revolution of workpiece.

In Feed: Roughing: Generally less than 0.005"; operator experience should guide this operation
Finishing: Should never exceed 0.001 to 0.002 inch.

Coolant: Coating should be sealed so that coolant can be used

Coating & Spray Parameters - Requires a Bond Coat of UltraBond 50000

TD 2000

Nozzle: RL 200
RotoJet: RPA-3@ 30 psi air
Module Adaptor: Yellow/Red
Oxygen: 50 psi / 35 flow (FM-1 flowmeter)
Acetylene: 12 psi / 75 flow (FM-1 flowmeter)
T-Valve Setting: 18 clicks
Coating Rate: 16 lb/hr
Spray Distance: 7 to 8 inches

TD 3000

Nozzle: RL 210W (or 3310)
RotoJet: RPA-3@25 psi air
Oxygen: 50 psi / 38 flow
Acetylene: 12 psi / 60 flow
Carrier Gas: Nitrogen 55 psi / 37 flow
Terometer: 125
Coating Rate: 20 lb/hr
Spray Distance: 8 to 12 inches
Air Vibrator: 20 psi

TYPICAL APPLICATIONS

- Pistons
- Bell housings
- Pump parts
- Wear rings
- Cylinder liners
- Rolls

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 T55-85, "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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