Castolin Eutectic®
Eutectic Castolin

An Atomized, Tin-Based Alloy Powder

Eutectic® 29240

- Designed for use with thermal spray equipment using the LT Accessory Air Shroud Package
- The tin alloy is similar to SAE 23 type II Babbitt
- Used for rebuilding most common tin-based Babbitt bearings
- Not recommended for bearings containing significant amounts of lead

Eutectic® 29240

29240 is an atomized tin-based alloy powder suitable for coating applications using combustion thermal spray equipment such as the TeroDyn® 2000 or TeroDyn 3000 systems when equipped with the specially designed low temperature LT Accessory Air Shroud Package. The tin alloy is similar to SAE 23 type II Babbitt. It can be used for rebuilding most common tin-based babbitt bearings. It is not recommended for those containing significant amounts of lead.

TECHNICAL DATA

Typical Powder Properties	
Nominal Composition:	Tin, Copper, Antimony, Lead
Hall Flow Rate:	17 seconds
Bulk Density:	4.0 g/cc
Powder Coverage:	0.06 lbs/ft² @ 0.001''
Typical Coating Properites	
Hardness:	Rockwell Y Scale 30
Bond Strength (ASTM C633):	Tinned with 157 PA: 7,000 psi Bond coat - Ni/Al: 2,000 psi
Maximum Service Temperature:	250°F (121°C)
Density:	6.67 g/cc
Melting Point:	466°F (241°C)
Thickness Limitation:	None

PROCEDURE FOR USE

Recommended Parameters

TD 2000 (Oxy-Acetylene)

Nozzle:	LT 250
LT Air Shroud:	30 psi
Module Adaptor:	Red/Yellow
Oxygen:	50 psi / 28 flow
Fuel Gas:	Acetylene @ 12 psi / 32 flow
T-Valve Setting:	13 clicks
Coating Rate:	20 lb/hr
Spray Distance:	4 to 6 inches

TD 2000 (Oxy-Propylene)

Nozzle:	LT 260P
LT Air Shroud:	30 psi
Module Adaptor:	Red/Yellow
Oxygen:	80 psi / 24 flow
Fuel Gas:	Propylene* @ 30 psi / 24 flow
T-Valve Setting:	10 clicks
Coating Rate:	20 lb/hr
Spray Distance:	5 to 6 inches

**Use Linde grade FG-2 or equivalent*

TD 3000

Nozzle:	LT 250
LT Air Shroud:	40 psi
Acetylene:	12 psi / 32 flow
Oxygen:	50 psi / 32 flow
Carrier Gas:	(Ni or Ar) 55 psi / 40 flow
Terometer**:	100
Spray Rate:	40 lb/hr
Air Vibrator:	20 psi

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

TYPICAL APPLICATIONS

- Heavy-duty bearings
- Turbine bearings
- High-speed bearings
- Split bearings
- Drive-shaft bearings

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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