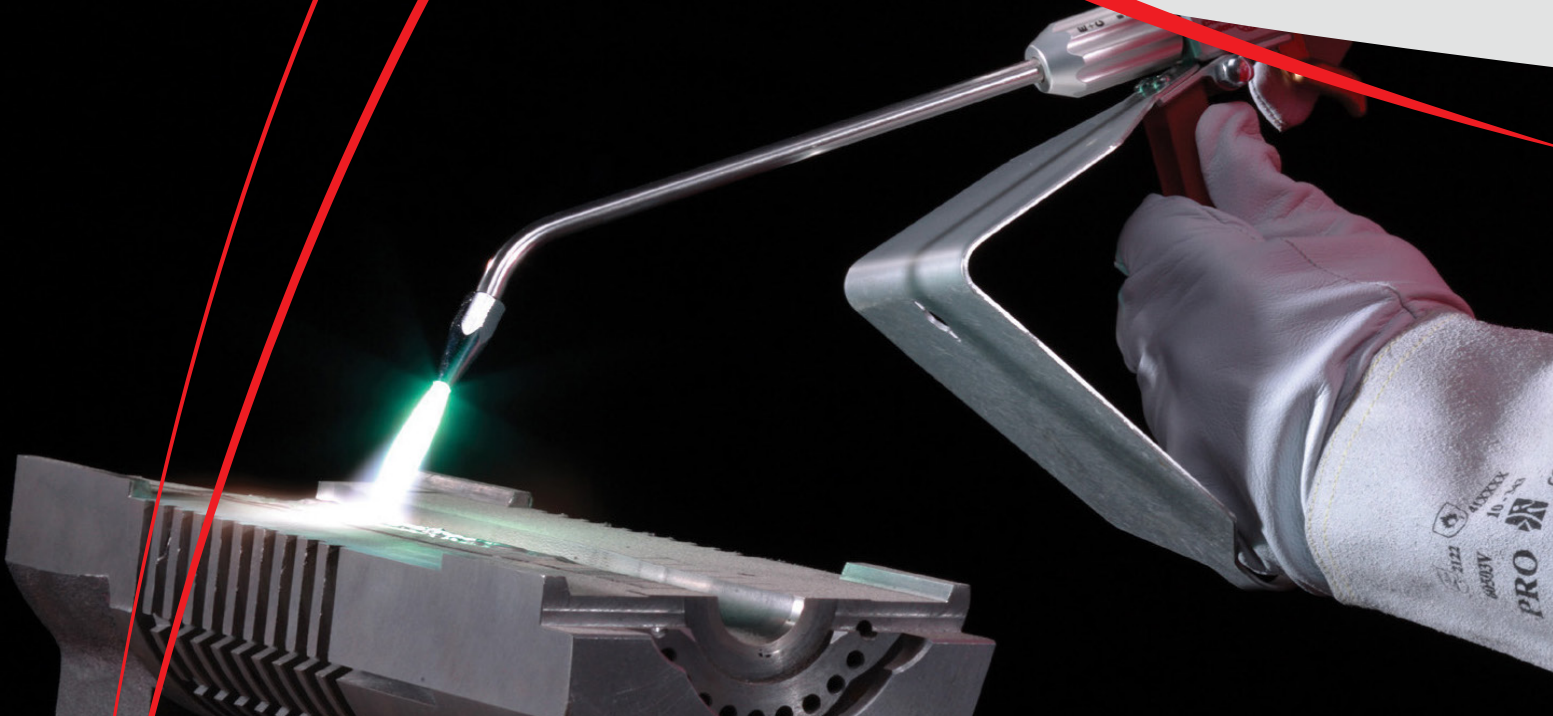




Nickel-Based Alloy Recommended for
Glass Mold Protection and Repair

Glass Mold 1210



- Ideal for protective coating, joining and cladding applications
- The deposit is easy to machine with carbide cutting tools
- Exceptionally heat resistant
- Ideal for protection against metal-to-metal friction

Glass Mold 1210

Glass Mold 1210 is a unique mid-range hardness alloy with exceptional wettability and point-to-point deposition control. Coatings have unlimited build-up capability and can be machined with carbide toolbits.

Glass Mold 1210 is manufactured by a process of atomization, designed to ensure both optimum spheroidization and controlled granulometry. This in turn ensures trouble-free fusion of the alloy using our SuperJet-S Eutalloy torch. Glass Mold 1210, applied with the Eutalloy system, produces smooth and uniform quality coatings.

This maintenance-engineered coating technology increases the value and reliability of parts treated, with results far superior to conventional repair processes, and savings in costs including those of machining.

Glass Mold 1210 is recommended for rectifying both machining and casting defects on glass molds, as well as for protective coatings against oxidation, with a considerable gain in service life for a number of parts.

TECHNICAL DATA

Typical Values	
Hardness:	25-27 HRC
Max Service Temperature:	1100°F (590°C)
Metal-to-Metal Friction:	Excellent
Corrosion Resistance:	Very Good
Machinability:	Carbide cutting tools
Torch:	SuperJet S

PROCEDURE FOR USE

Preparation: All surfaces to be coated should be thoroughly cleaned, removing all contaminants, oxides and grease.

Coating Instructions: For coating operations the flame of the 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 Glass Mold 1210.

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 0.25 - 0.75 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

Recommended for corrosion/wear-resistant coatings on glass mold edges and corners especially when used on bronze-type alloys.

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.



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

