



Fusible, Nickel-Chrome-Moly
HVOF Thermal Spray Powder

TeroJet 55606



- High bond strength on a wide variety of base metals
- Best combination of abrasion and corrosion resistance, especially in chloride conditions
- May be used as-sprayed or thermally fused
- Hard, dense coatings with excellent corrosion resistance

TeroJet 55606

TeroJet 55606 is a self-fluxing, Nickel based, highly alloyed powder. Water atomized coatings of 55606 may be used in the as-sprayed condition or subsequently fused with a heating torch. The fusing operation will densify the coating and will produce metallurgical bonding to the base metal. For applications where it is desirable to use the coating in the as-sprayed, HVOF is the preferred method of application. The coatings produced are hard, dense and will exhibit high bond strengths to a wide variety of base metals.

TECHNICAL DATA

Typical Values	
Hardness / R15N:	85-88 (HRC 50-54 converted)
Bond Strength:	>5,000 psi (ASTM C633)
Porosity:	< 3 %
Oxides:	< 2 %
Coating Density:	7.86 g/cc (as sprayed) 8.10 (fused)
Service Temperature:	1200°F / 649°C (Max)
As-Sprayed Roughness:	< 250 micro-inches AA
As-Ground Roughness:	< 25 micro-inches AA
As-Ground and Lapped:	< 10 micro-inches AA
Wear Resistance: (ASTM G65, Sch. A)	31 x 10 ⁻³ mm ³ volume loss

Powder Properties:

Chromium, Nickel, Molybdenum, Silicon,
Boron, Copper

PROCEDURE FOR USE:

Finishing Procedure

Coatings of TeroJet 55606 may be finished by grinding using silicon carbide wheels with flood coolant. Follow the tool manufacturer's recommendations for speeds and feeds.

TYPICAL APPLICATIONS

A Ni-base alloy designed for HVOF delivery systems to provide protective coatings for components in environments of extreme abrasion and corrosion (both oxidizing and reducing) in waste incineration, pulp and paper, and chemical industries. Boiler tubes, extruder screws, shafts, sleeves and mixer blades.

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 web site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH.



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