

THERMAL SPRAY FLEXICORD

Technical Bulletin



ROCDUR 40

RocDur series – ref : 98217 2347 000

ROCDUR 40 Flexicord is designed to be sprayed (with our MASTER JET® flame spray gun) and fused. ROCDUR 40 provides medium wear resistant coatings as well as a good thermal aging resistance. ROCDUR 40 is suitable for build-up and repair of worn molds and other parts requiring wear resistant and impact resistant coating. Low cracking occurrence risk. Good corrosion resistant coating.

Applications

Glassworks components (molds, press and blow plungers...), wide and/or concave surfaces highly thermally stressed, mechanical parts rebuilding. Post fusion only with acetylene.

Typical composition (%) - T^{TIP}

Ni 7,5Cr 1,6B 3,5Si 2,5Fe 0,25C

Color code

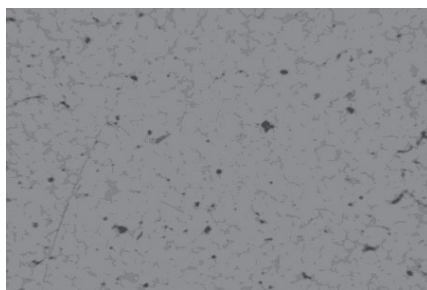
Skin Red

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,4 Kg +/- 10%

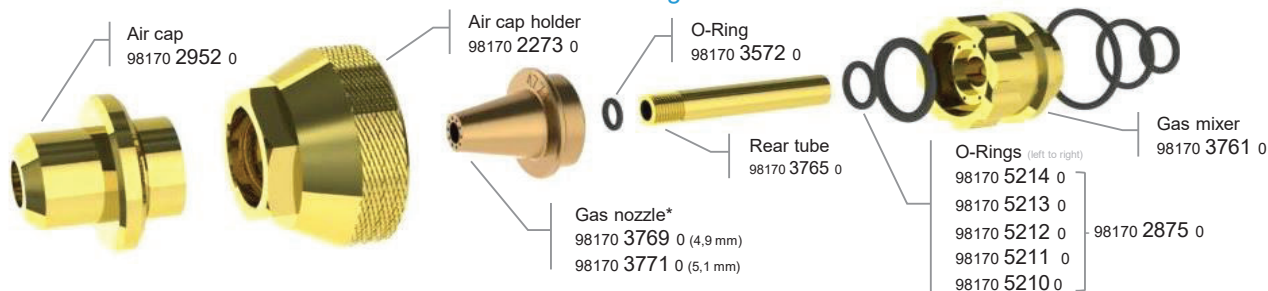


Typical microstructure of RocDur 40 sprayed with our Master Jet® flame spray gun and fused.

Coating features

Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	12,5 µm
Hardness (after fusion)	425 Hv ₃₀₀ (40 HRC)
Density	8,1 g/cm ³
Deposit Efficiency	83% to 90%
Melting point	~1030°C (1870°F)

Gun configuration

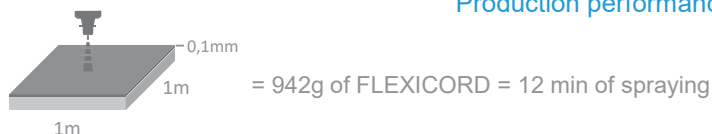


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



SAINT-GOBAIN COATING SOLUTIONS

