

THERMAL SPRAY FLEXICORD

Technical Bulletin



ROCDUR 625

Special alloys series – ref : 98217 6047 000

ROCDUR 625 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 625 provides dense and smooth coating with low porosity. Oxidation resistant. Best corrosion–resistance coating among all Flexicord products. ROCDUR 625 withstands many corrosive environments: alkaline, sea water. Low residual oxidation after spraying. Nonmagnetic. Ideal material for temperature ranging from cryogenic to 1093°C (2000°F). Can be finished by bead blasting to reduce Roughness Ra and to seal the surface.

Applications

Protection of boiler tubes, parts subjects to sea water corrosion, section of waste energy plants.

Typical composition (%) - T^{TIP}

Ni Cr Mo Fe alloy

Color code

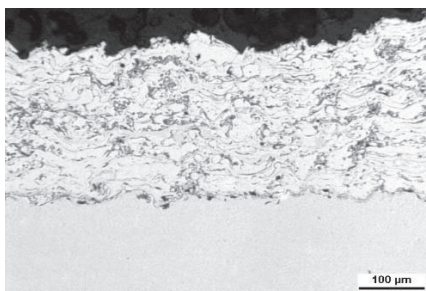
Skin Red

Packaging

Ø Flexicord 4,75 mm $\pm$ 0,1mm

Spool Plastic - SD 300mm

Weight 8 Kg $\pm$ 10%



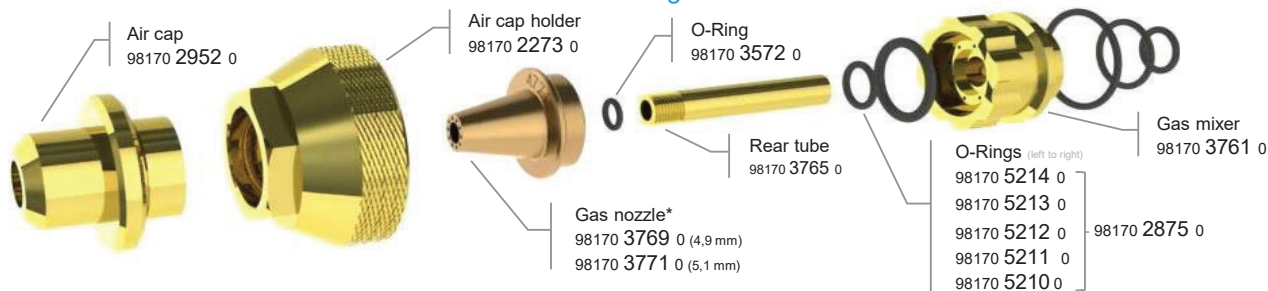
Typical microstructure of RocDur 625 sprayed with our Master Jet® flame spray gun.

Coating features

Porosity	2 – 5%
Pore diameter	5 – 10 µm
Roughness Ra (as sprayed)	6 – 8 µm
Hardness	340 Hv ₃₀₀
Density	8,44 g/cm ³
Deposit Efficiency	80%
Melting point	1350°C (2460°F)

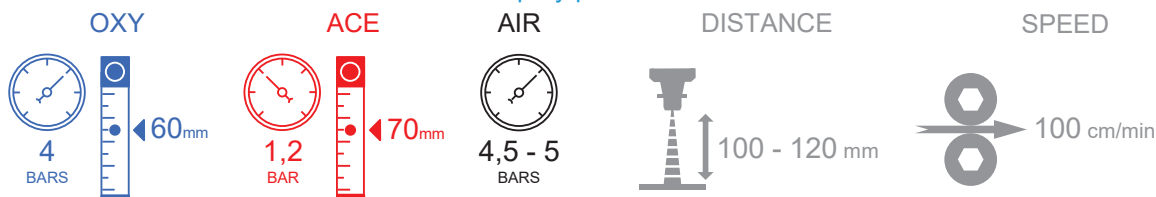
Similar composition to Inconel® 625*

Gun configuration

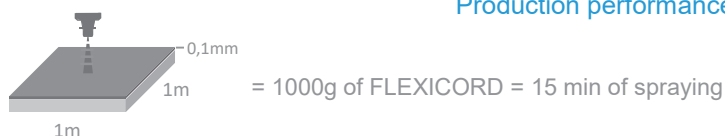


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



SAINT-GOBAIN COATING SOLUTIONS



* Inconel® is a registered Trademark from Inco