

THERMAL SPRAY FLEXICORD

Technical Bulletin



ROCDUR Co12

RocDur series – ref : 98217 5247 000

ROCDUR Co12 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun and fuse . ROCDUR Co12 provides Hardness kept up to high temperatures. Good tribological behavior. Good wear resistance.

Applications

Glassworks components for severe working conditions at high temperature (plungers, rings, ...), friction / Wear resistant surfaces up to 600 °C. Post fusion only with acetylene.

Typical composition (%) - T^{TIP}

Co 13Ni 19Cr 9W 3,2Fe 2,8Si 1,8B 1,2C

Color code

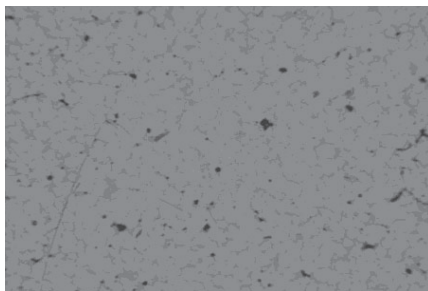
Skin Blue

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11 Kg +/- 10%

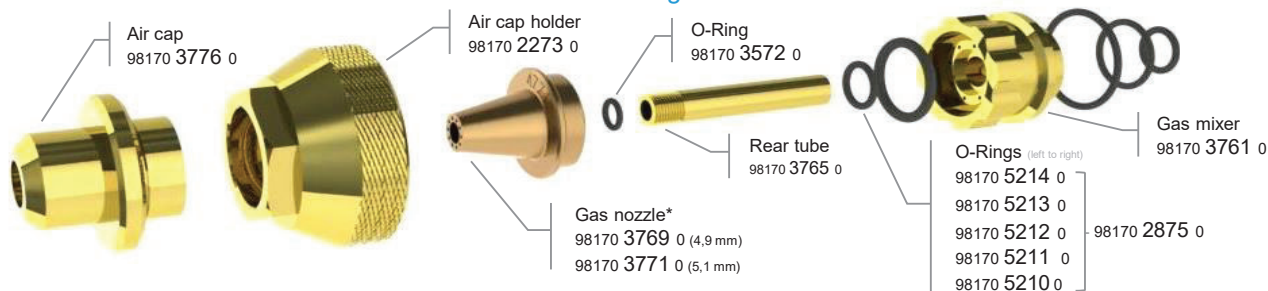


Typical microstructure of RocDur Co12 sprayed with our Master Jet® flame spray gun and fused.

Coating features

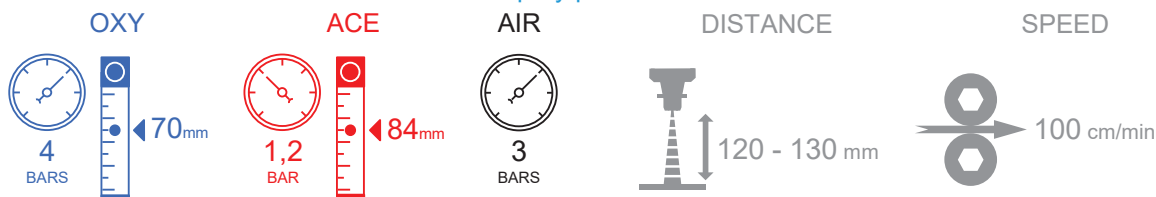
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	12 - 15 µm
Hardness	530 Hv ₃₀₀ (20°C) 440 Hv ₃₀₀ (400°C) 280 Hv ₃₀₀ (600°C)
Density	8,35 g/cm ³
Deposit Efficiency	83% to 90%
Melting point	~1080°C (1976°F)

Gun configuration

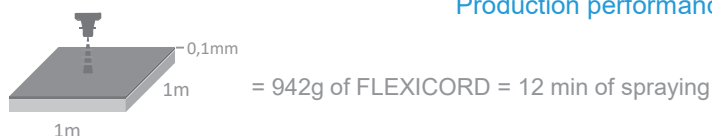


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



SAINT-GOBAIN COATING SOLUTIONS

