

THERMAL SPRAY FLEXICORD

Technical Bulletin



ROCDUR Co6
RocDur series – ref : 98217 5147 000

ROCDUR Co6 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun and fuse . ROCDUR Co6 provides Hardness kept up to high temperatures (turns higher than ROCDUR Co12 for temperatures above 500°C). 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 7,3W 2,8Fe 2,6Si 1,6B 0,8C

Color code

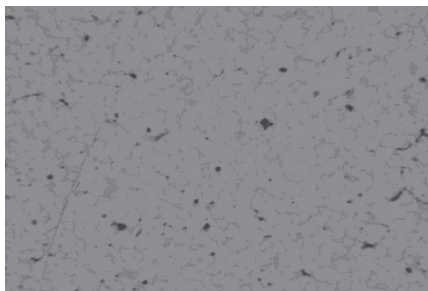
Skin Blue

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11 Kg +/- 10%

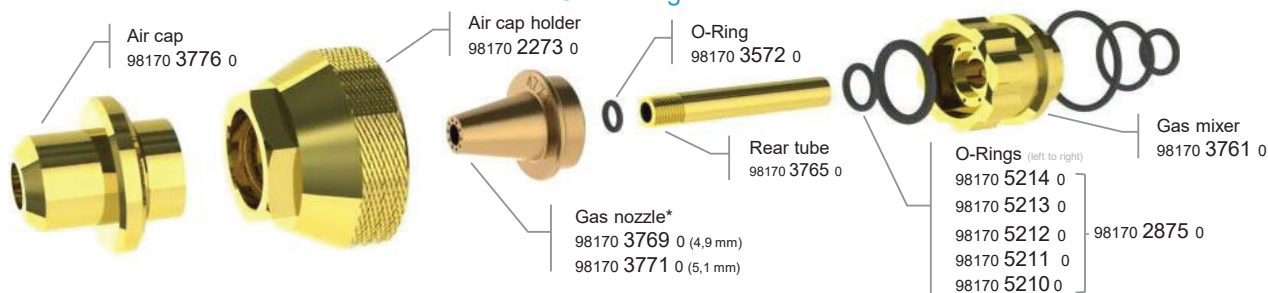


Typical microstructure of RocDur Co6 sprayed with our Master Jet® flame spray gun and fused.

Coating features

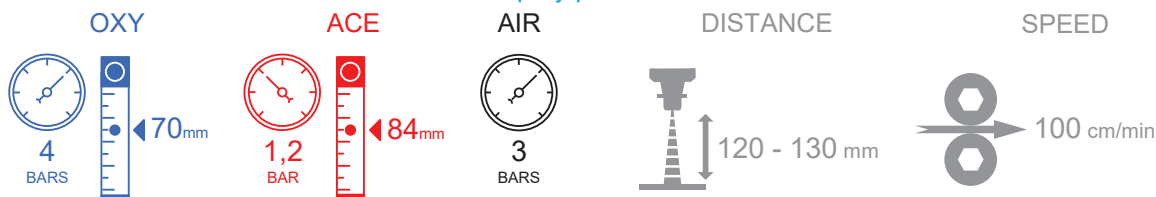
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	12 - 15 µm
Hardness	450 Hv ₃₀₀ (20°C) 400 Hv ₃₀₀ (400°C) 300 Hv ₃₀₀ (600°C)
Density	8,3 g/cm ³
Deposit Efficiency	83% to 90%
Melting point	~1120°C (2048°F)

Gun configuration

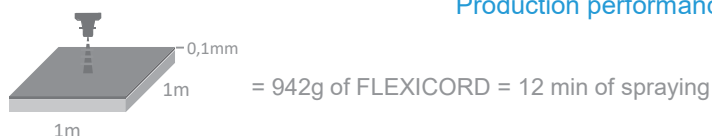


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



SAINT-GOBAIN COATING SOLUTIONS

