

THERMAL SPRAY FLEXICORD

Technical Bulletin



HARDKARB 12 Co

Carbide series – ref : 98217 0847 000
for grinded coating

HARDKARB 12 Co Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. HARDKARB 12 Co Flexicord provides hard, tough and dense coating. Sliding wear resistant, erosion, fretting and abrasion resistant coatings. Low resistance to oxidation and corrosion. Used at service temperature up to 480°C (900°F).

Applications

Pump housings, machine parts, capstans, rollers, exhaust fans, dust collectors, dust pipes and elbows, rotating valves, wire drawing.

Typical composition (%) - T^{TIP}

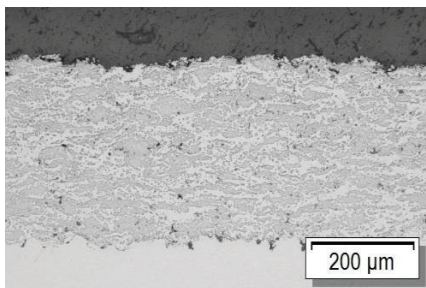
WC	88
Co	12

Color code

Skin	Red
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Packaging

Ø Flexicord	4,75 mm +/- 0,1mm
Spool	Plastic - SD 300mm
Weight	12,1 Kg +/- 10%

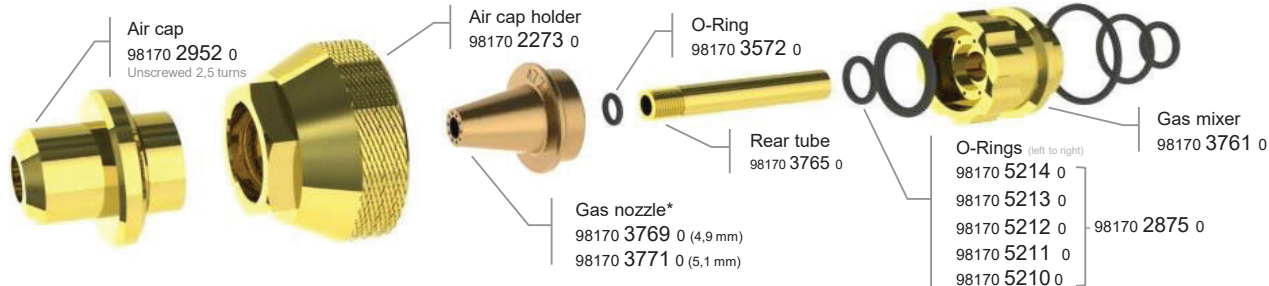


Typical microstructure of HardKarb 12 Co sprayed with our Master Jet® flame spray gun.

Coating features

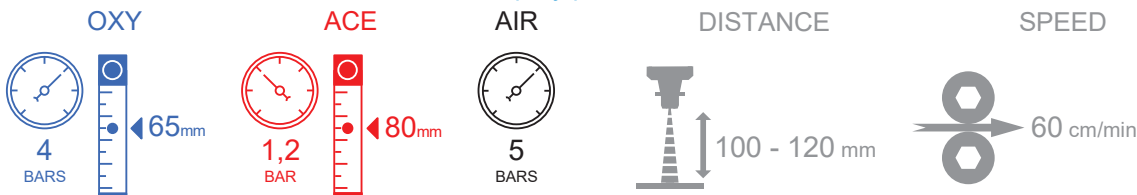
Porosity	1%
Pore diameter	5 - 10 µm
Roughness Ra (as sprayed)	4,5 – 6,5 µm
Hardness	1300 Hv ₃₀₀
Density	13,2 g/cm ³
Deposit Efficiency	78%

Gun configuration

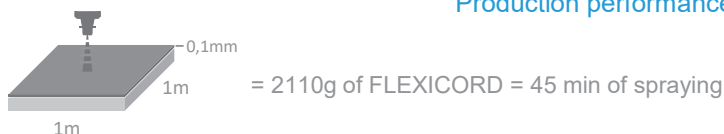


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



THERMAL SPRAY FLEXICORD

Technical Bulletin



HARDKARB 12 Co

Carbide series – ref : 98217 0847 000
for high deposition rate coating

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Applications

Pump housings, machine parts, capstans, rollers, exhaust fans, dust collectors, dust pipes and elbows, rotating valves, wire drawing.

Typical composition (%) - TTIP

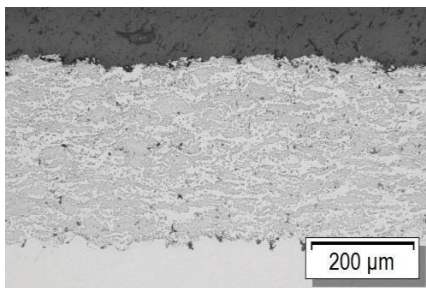
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Packaging

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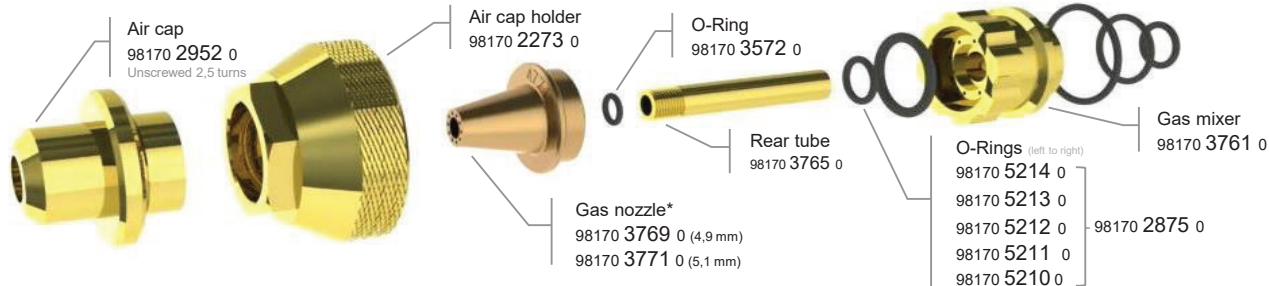


Typical microstructure of HardKarb 12 Co sprayed with our Master Jet® flame spray gun.

Coating features

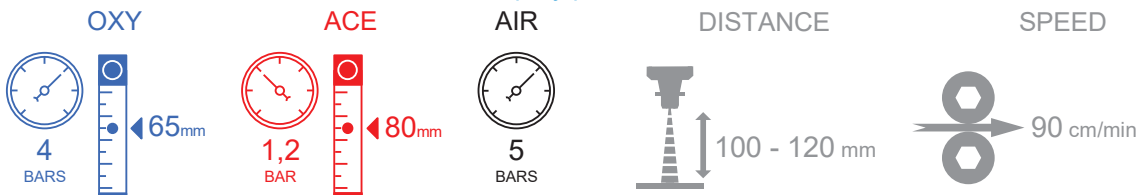
Porosity	1%
Pore diameter	5 - 10 µm
Roughness Ra (as sprayed)	4,5 – 6,5 µm
Hardness	1300 Hv ₃₀₀
Density	13,2 g/cm ³
Deposit Efficiency	78%

Gun configuration



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

Spray parameters



Production performances

