

THERMAL SPRAY FLEXICORD

Technical Bulletin



HARDKARB 15 HC

Carbide series – ref : 98217 0347 000

HARDKARB 15 HC Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. HARDKARB 15 HC Flexicord provides hard, tough and dense coating. Abrasion resistant coatings for corrosive environment with hydrocarbons for applications in oil and gas market. Sliding wear resistant, erosion and fretting resistant coating. Used at service temperature up to 500°C (932°F).

Applications

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

Typical composition (%) - T^{TIP}

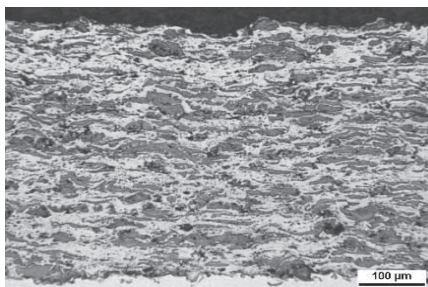
WC	85
Ni	10
2,75Cr 2,75Mo 1,15Fe 0,45Co	

Color code

Skin	Red
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Packaging

Ø Flexicord	4,75 mm +/- 0,1mm
Spool	Plastic - SD 300mm
Weight	11,9 Kg +/- 10%

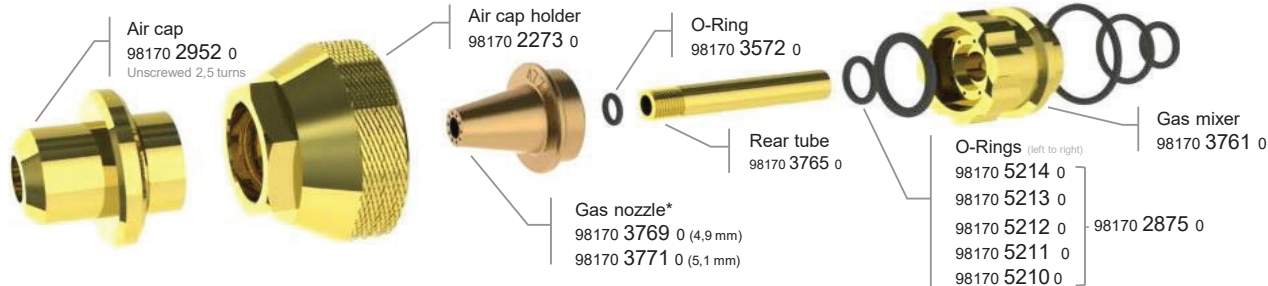


Typical microstructure of HardKarb 15 HC sprayed with our Master Jet® flame spray gun.

Coating features

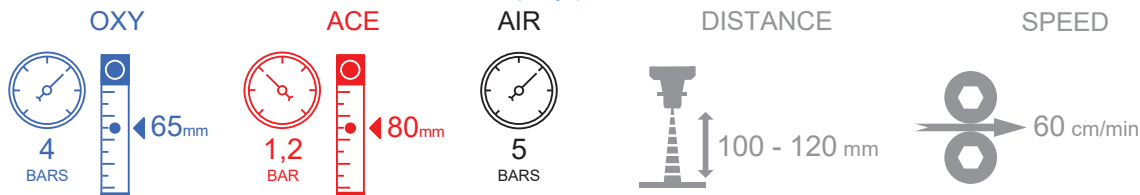
Porosity	3 – 6,5%
Pore diameter	5 - 15 µm
Roughness Ra (as sprayed)	4,5 – 6,5 µm
Hardness	1000 - 1100 Hv ₃₀₀
Density	13,3 g/cm ³
Deposit Efficiency	65%

Gun configuration

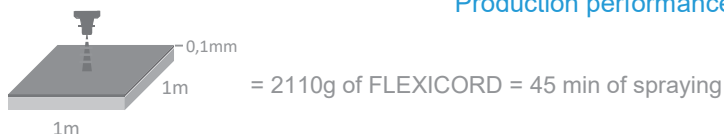


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



SAINT-GOBAIN COATING SOLUTIONS

