

THERMAL SPRAY FLEXICORD

Technical Bulletin



HARDKARB CoCr

Carbide series – ref : 98217 0747 000

HARDKARB CoCr Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. HARDKARB CoCr Flexicord provides hard, tough and dense coating.

Abrasion resistant coatings for corrosive environment (water, clay, slurry, petrochemical), 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}

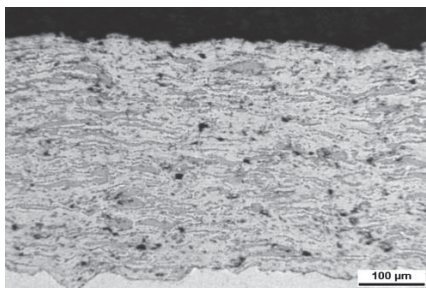
| | |
|----|----|
| WC | 86 |
| Co | 10 |
| Cr | 4 |

Color code

| | |
|------|-----|
| Skin | Red |
|------|-----|

Packaging

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

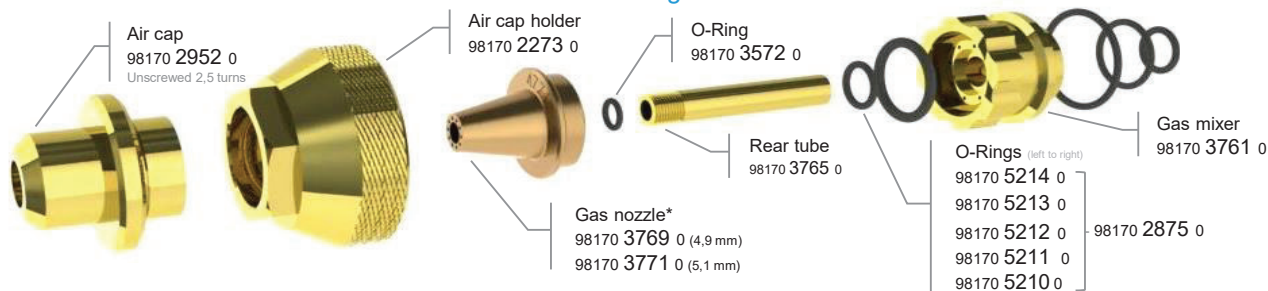


Typical microstructure of HardKarb CoCr sprayed with our Master Jet® flame spray gun.

Coating features

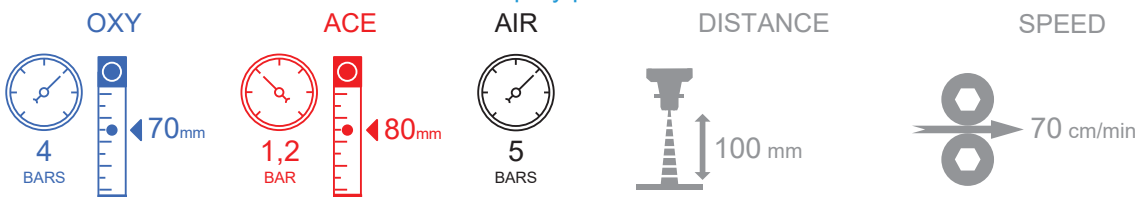
| | |
|---------------------------|------------------------|
| Porosity | 3 – 4% |
| Pore diameter | 5 - 10 µm |
| Roughness Ra (as sprayed) | 4,5 – 6,5 µm |
| Hardness | 1240 Hv ₃₀₀ |
| Density | 13,2 g/cm ³ |
| Deposit Efficiency | 65% |

Gun configuration



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

Spray parameters



Production performances

