

THERMAL SPRAY FLEXICORD

Technical Bulletin

Bond Coat series – ref : 98216 0547 000

NICHROME Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. NICHROME is a bond coat material used to improve the bond strength of the top coat such as ceramic coatings. It provides: low porosity, oxidation resistant and relatively smooth coatings. Ideal choice for our ceramic supra series. Not recommended on cast iron and Mn, Mg steel alloys – use our NiCrAlY.

Applications

Bond coat for all purpose ceramic coatings on steel. Good resistance to oxidation at high temperature up to 1000°C. We recommend to apply Ni-Chrome no more than 200 µm. A slight preheating at 120°C improves the bonding. Can also be used as monolayer.

Typical composition (%) - GTIP

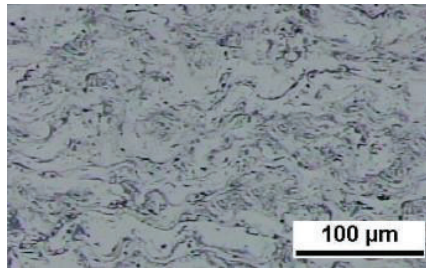
Ni	80
Cr	20

Color code

Skin	Blue
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Packaging

Ø Flexicord	4,75 mm +/- 0,1mm
Spool	Plastic - SD 300mm
Weight	8 Kg +/- 10%

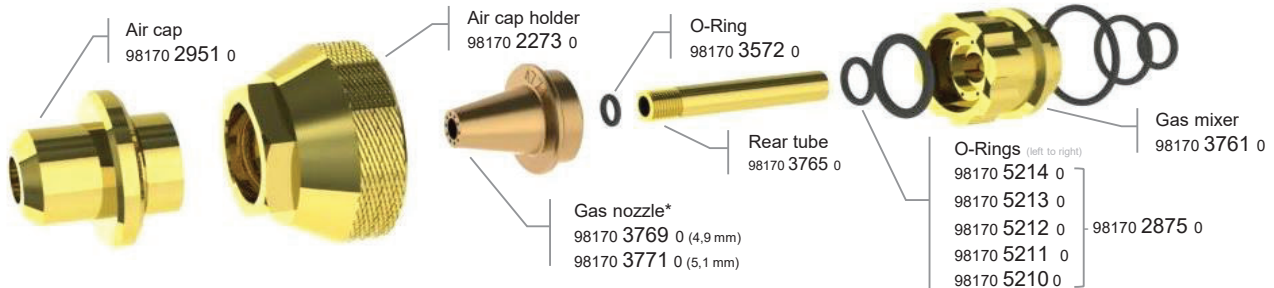


Typical microstructure of NiChrome sprayed with our Master Jet® flame spray gun.

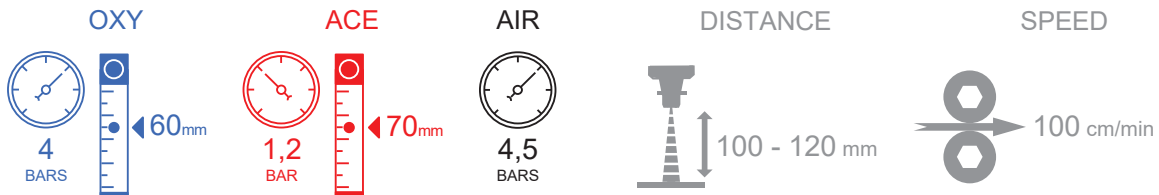
Coating features

Porosity	1 - 3%
Pore diameter	5 - 10 µm
Roughness Ra (as sprayed)	6 - 8 µm
Hardness	280 Hv ₃₀₀
Density	7,25 g/cm ³
Deposit Efficiency	45%
Melting point	1400°C (2552°F)

Gun configuration



Spray parameters



Production performances

