

THERMAL SPRAY FLEXICORD

Technical Bulletin



ROCDUR 37

RocDur series – ref : 98217 3047 000

ROCDUR 37 Flexicord is designed to be sprayed (with our MASTER JET® flame spray gun) and fused. ROCDUR 37 provides medium wear resistant coatings as well as a good thermal aging resistance. ROCDUR 37 can also be used as a bond coat for ROCDUR 6750/6740. Very good resistance to thermal shocks, good corrosion resistance, low cracking occurrence risk.

Applications

Glassworks components (molds, press and blow plungers...), wide and/or concave surfaces highly thermally stressed, mechanical parts rebuilding, can be used as a bond coat for RocDur 6750 and RocDur 6740. Post fusion only with acetylene.

Typical composition (%) - T^{TIP}

Ni 7Cr 1,2B 3,7Si 3Fe 0,32C

Color code

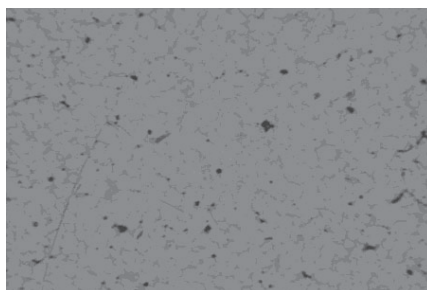
Skin Red

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,5 Kg +/- 10%

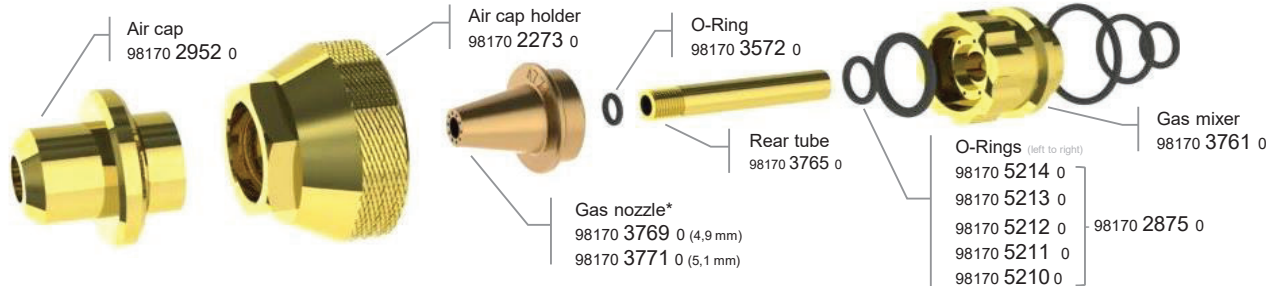


Typical microstructure of RocDur 37 sprayed with our Master Jet® flame spray gun and fused.

Coating features

| | |
|---------------------------|-----------------------------|
| Porosity | < 1% as fused |
| Pore diameter | < 1 µm as fused |
| Roughness Ra (as sprayed) | 12,5 µm |
| Hardness (after fusion) | 335 – 380 Hv ₃₀₀ |
| Density | 8,1 g/cm ³ |
| Deposit Efficiency | 83% to 90% |
| Melting point | ~1030°C (1870°F) |

Gun configuration



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

Spray parameters



Production performances

