

# THERMAL SPRAY FLEXICORD

Technical Bulletin



## ROCDUR 6728

RocDur series – ref : 98210 6470 000

ROCDUR 6728 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 6728 can be used either as sprayed or subsequently fused. It provides highly abrasion and erosion wear resistant coatings or when fused.

### Applications

Wear resistance coating for feed rollers, guides, capstans for wire drawing and drawing mills, excavator screws for abrasive materials, wear parts of mixing tools. Post fusion only with acetylene.

### Typical composition (%) - T<sup>TIP</sup>

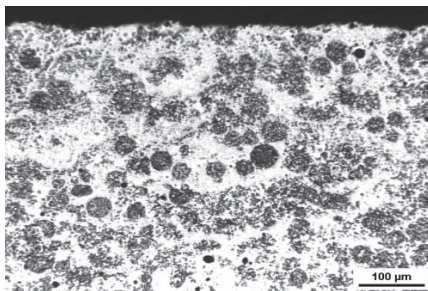
NiCrBSi	72
WC	28

### Color code

Skin	Red
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### Packaging

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

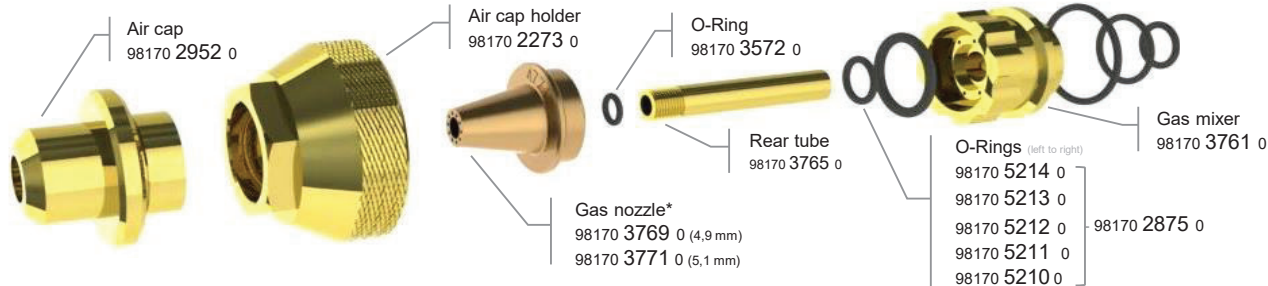


Typical microstructure of RocDur 6728 sprayed with our Master Jet® flame spray gun and fused.

### Coating features

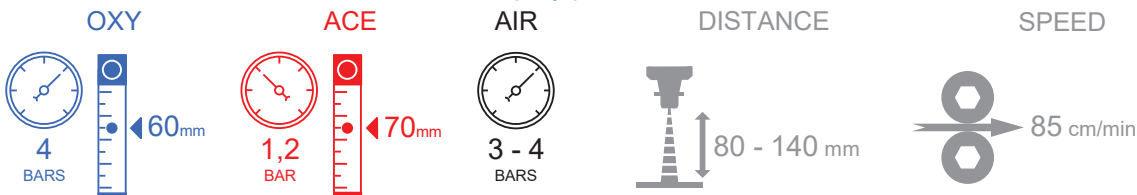
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	8-10 µm
Hardness	Matrix - 60HRC WC - 1200 Hv <sub>300</sub>
Density	11,2 g/cm <sup>3</sup>
Deposit Efficiency	63% to 68%
Melting point	~1060°C (1940°F)

### Gun configuration



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

### Spray parameters



### Production performances

