

THERMAL SPRAY FLEXICORD

Technical Bulletin



ROCDUR 6740

RocDur series – ref : 98210 5470 000

ROCDUR 6740 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 6740 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 (%) - GTIP

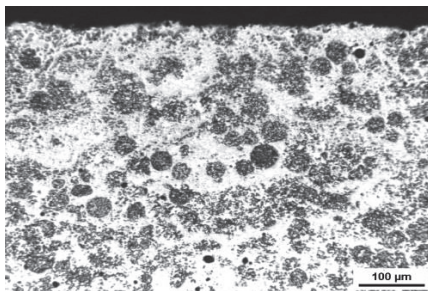
NiCrBSi	60
WC sintered	40

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%

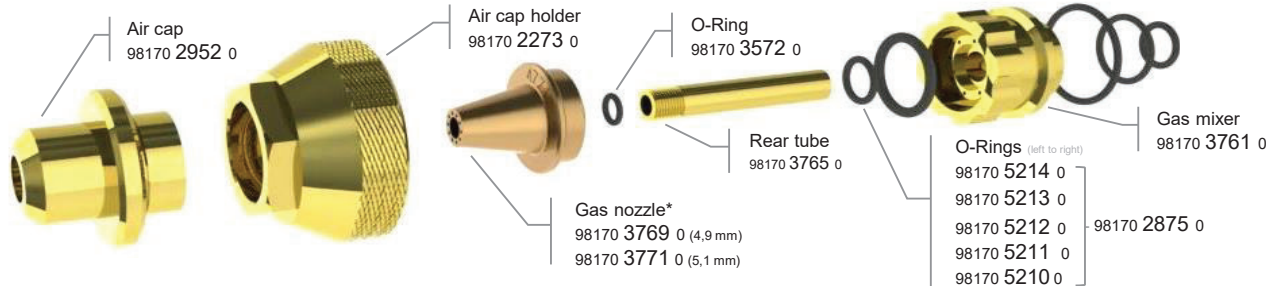


Typical microstructure of RocDur 6740 sprayed with our Master Jet® flame spray gun and fused.

Coating features

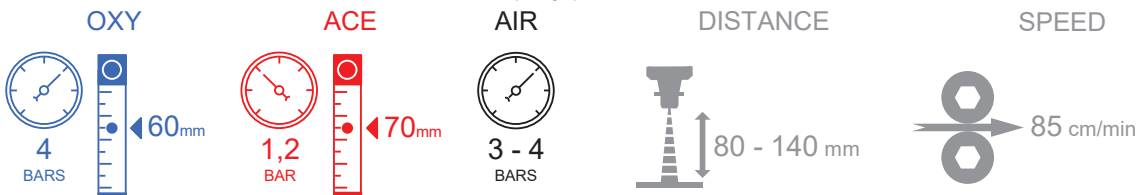
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	8-10 µm
Hardness	Matrix - 60HRC WC - 1200 Hv ₃₀₀
Density	11,2 g/cm ³
Deposit Efficiency	63% to 68%
Melting point	~1060°C (1940°F)

Gun configuration



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

Spray parameters



Production performances

