

THERMAL SPRAY FLEXICORD

Technical Bulletin



ALLOY COATING SUPPLY

ROCDUR 6750

RocDur series – ref : 98210 1347 000

ROCDUR 6750 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 6750 can be used as sprayed and fused for Abrasion and erosion wear resistant coatings or just as sprayed for non-slip application. Its Roughness Ra is higher than ROCDUR 6740 Roughness Ra.

Applications

Rolling mill rollers, excavator screws for abrasive materials, friction areas for mixing tools, inner parts of incinerators (tubes, blocks...). Drilling tools. Non-Slip applications (cardboard feeders,...). Post fusion only with acetylene.

Typical composition (%) - G^{TIP}

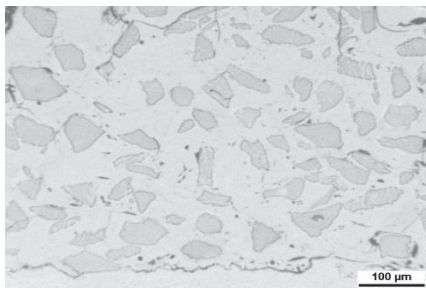
NiCrBSi	50
WC cast	50

Color code

Skin	Red
------	-----

Packaging

Ø Flexicord	4,75 mm +/- 0,1mm
Spool	Plastic - SD 300mm
Weight	12 Kg +/- 10%

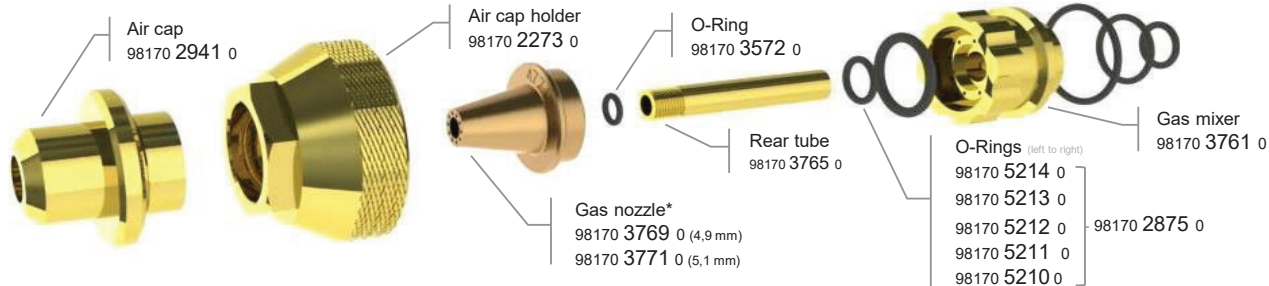


Typical microstructure of RocDur 6750 sprayed with our Master Jet® flame spray gun and fused.

Coating features

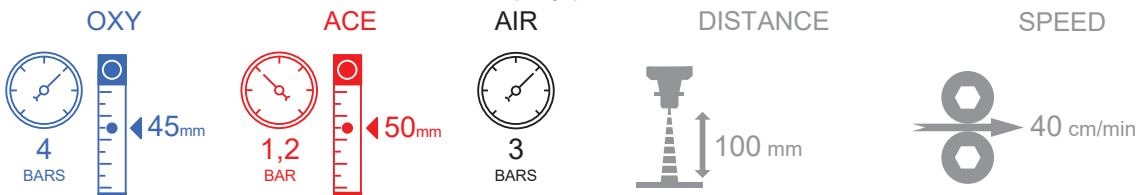
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	10-12 µm
Hardness (as fused)	Matrix - 60HRC WC - 2000 Hv ₃₀₀
Density	12 g/cm ³
Deposit Efficiency	65%
Melting point	~1060°C (1940°F)

Gun configuration



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

Spray parameters



Production performances

