

# THERMAL SPRAY FLEXICORD

## Technical Bulletin

# ROCDUR 29

RocDur series – ref : 98217 3147 000

ROCDUR 29 Flexicord is designed to be sprayed (with our MASTER JET® flame spray gun) and fused. ROCDUR 29 provides medium wear resistant coatings as well as a good thermal aging resistance and low cracking occurrence at post fusion. Very good resistance to thermal shocks. ROCDUR 29 can also be used as a bond coat for ROCDUR 6750/6740.

### Applications

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

### Typical composition (%) - TTIP

Ni 1,8B 2,7Si 0,8Fe 0,06C

### Color code

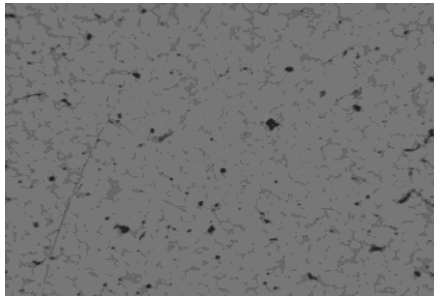
Skin Red

### Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,5 Kg +/- 10%

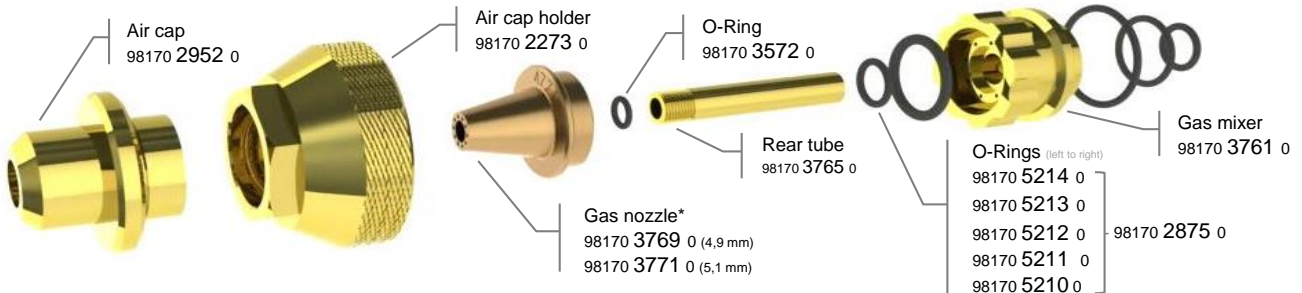


Typical microstructure of RocDur 29 sprayed with our Master Jet® flame spray gun and fused.

### Coating features

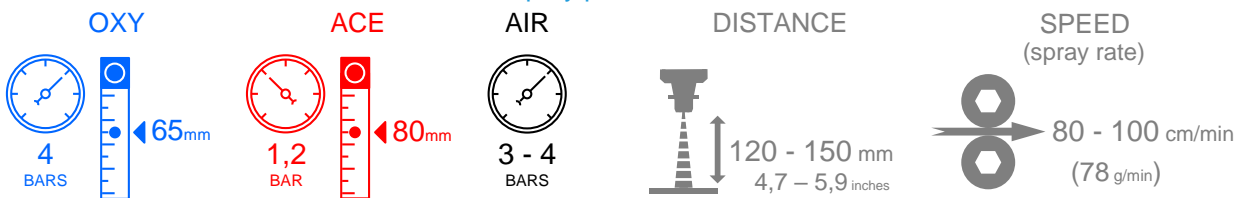
|                                 |                             |
|---------------------------------|-----------------------------|
| Porosity                        | < 1% as fused               |
| Pore diameter                   | < 1 µm as fused             |
| Roughness Ra (as sprayed)       | 12,5 µm                     |
| Typical Hardness (after fusion) | 210 – 275 Hv <sub>300</sub> |
| Density                         | 8,1 g/cm <sup>3</sup>       |
| Deposit Efficiency              | 83% to 90%                  |
| Melting point                   | ~1030°C (1870°F)            |

### Gun configuration

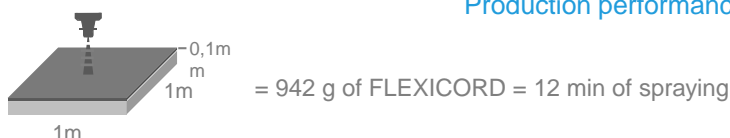


\*Use 4,9 mm in dry area – 5,1 mm in wet area

### Spray parameters



### Production performances



## SAINT-GOBAIN COATING SOLUTIONS

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