

# THERMAL SPRAY FLEXICORD

## Technical Bulletin

# ROCDUR 40

RocDur series – ref : 98217 2347 000

ROCDUR 40 Flexicord is designed to be sprayed (with our MASTER JET® flame spray gun) and fused. ROCDUR 40 provides medium wear resistant coatings as well as a good thermal aging resistance. ROCDUR 40 is suitable for build-up and repair of worn molds and other parts requiring wear resistant and impact resistant coating. Low cracking occurrence risk. Good corrosion resistant coating.

### Applications

Glassworks components (molds, press and blow plungers...), wide and/or concave surfaces highly thermally stressed, mechanical parts rebuilding. Post fusion only with acetylene.

### Typical composition (%) - TTIP

Ni 7,5Cr 1,6B 3,5Si 2,5Fe 0,25C

### Color code

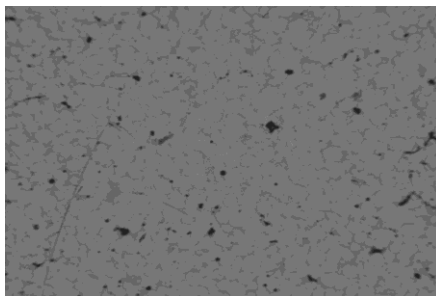
Skin Red

### Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,4 Kg +/- 10%

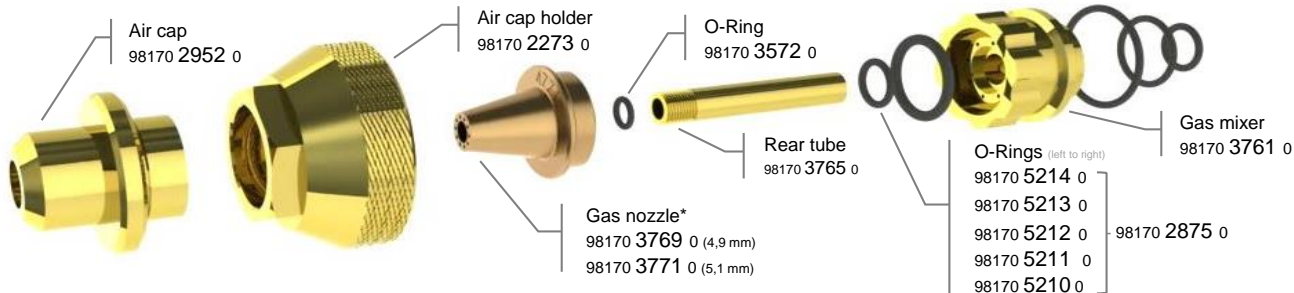


Typical microstructure of RocDur 40 sprayed with our Master Jet® flame spray gun and fused.

### Coating features

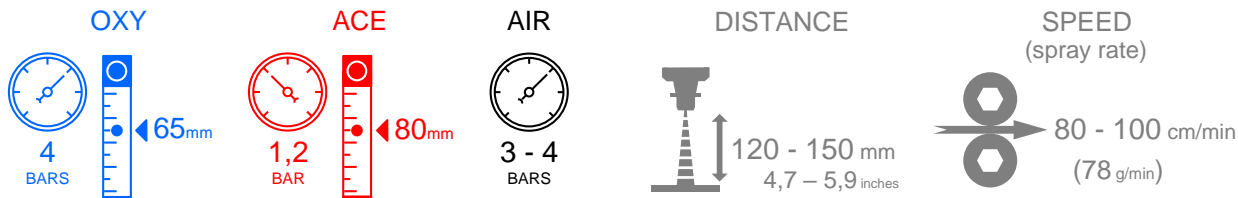
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	12,5 µm
Typical Hardness (after fusion)	425 Hv <sub>300</sub> (40 HRC)
Density	8,1 g/cm <sup>3</sup>
Deposit Efficiency	83% to 90%
Melting point	~1030°C (1870°F)

### Gun configuration

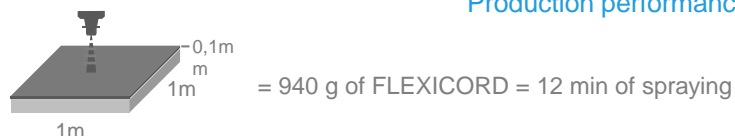


\*Use 4,9 mm in dry area – 5,1 mm in wet area

### Spray parameters



### Production performances



## SAINT-GOBAIN COATING SOLUTIONS

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