

THERMAL SPRAY FLEXICORD

Technical Bulletin

ROCDUR 62

RocDur series – ref : 98217 1147 000

ROCDUR 62 Flexicord is designed to be sprayed (with our MASTER JET® flame spray gun) and fused. ROCDUR 62 provides carbide-rich matrix, wear resistant coatings, especially for narrow neck plungers. ROCDUR 62 is very competitive versus HVOF-process. Very high hardness thanks to its carbide-rich matrix. Good corrosion resistance.

Applications

Glassworks components (narrow neck plungers), rollers requiring abrasion and wear surface with an excellent bonding and medium impact resistance, mechanical parts rebuilding. Post fusion only with acetylene.

Typical composition (%) - T^{TIP}

Ni 14,3Cr 9,5W 2,8B 3,7Si 3,5Fe 0,6C

Color code

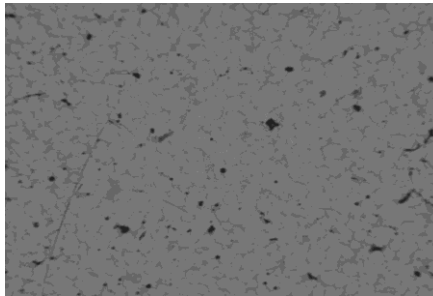
Skin Red

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,4 Kg +/- 10%

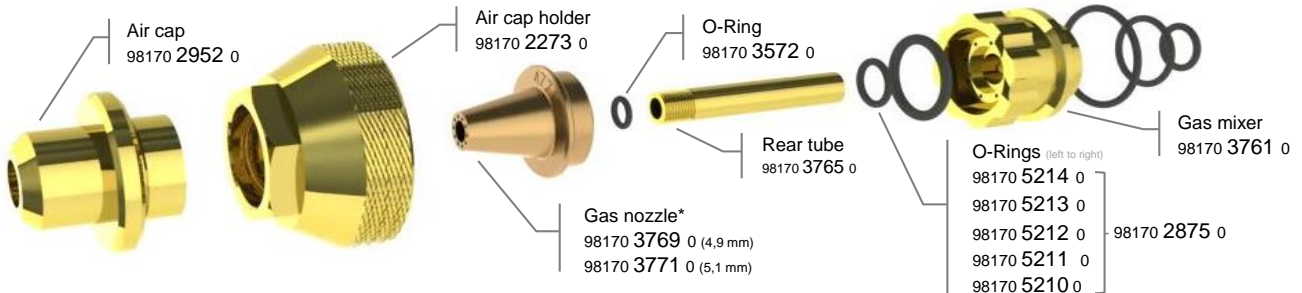


Typical microstructure of RocDur 62 sprayed with our Master Jet® flame spray gun and fused.

Coating features

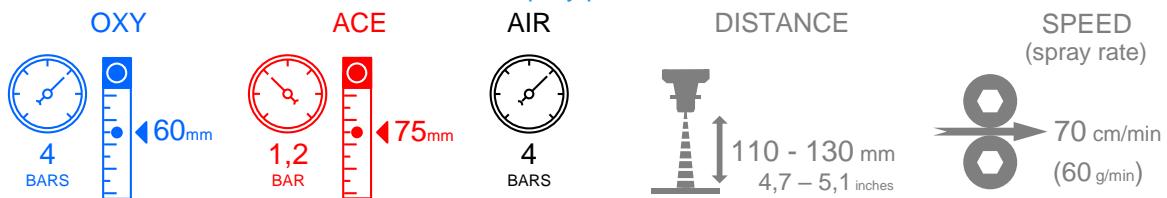
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	12,5 µm
Typical Hardness (after fusion)	59 – 62 HRC
Density	8,1 g/cm ³
Deposit Efficiency	82%
Melting point	~1030°C (1870°F)

Gun configuration

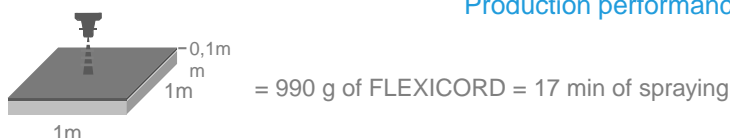


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



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