

THERMAL SPRAY FLEXICORD

Technical Bulletin

ROCDUR 6728

RocDur series – ref : 98210 6470 000

ROCDUR 6728 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 6728 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 (%) - T^{TIP}

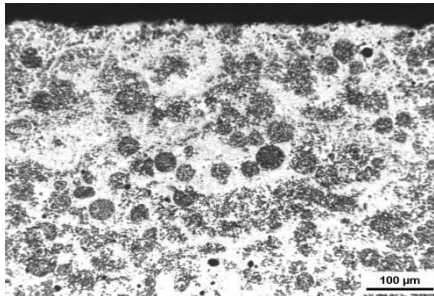
NiCrBSi	72
WC	28

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%

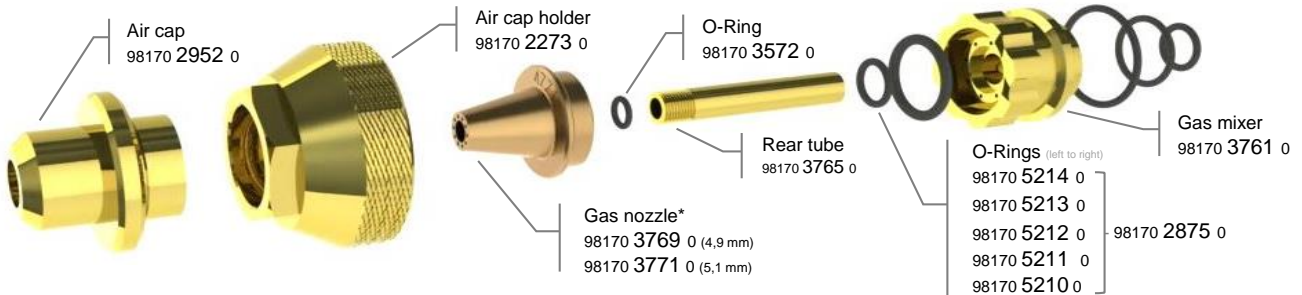


Typical microstructure of RocDur 6728 sprayed with our Master Jet® flame spray gun and fused.

Coating features

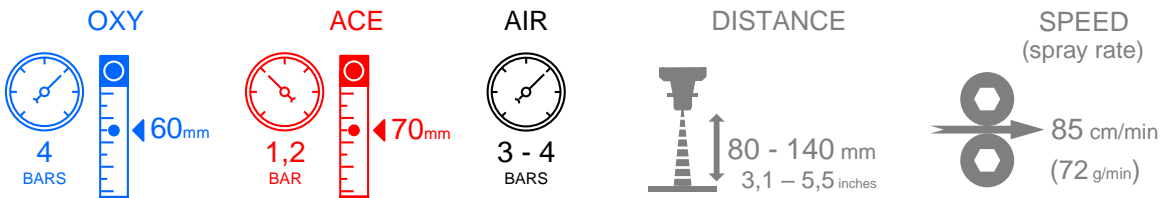
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	8-10 µm
Typical Hardness	Matrix - 60HRC WC - 1200 Hv ₃₀₀
Density	11,2 g/cm ³
Deposit Efficiency	63% to 68%
Melting point	~1060°C (1940°F)

Gun configuration

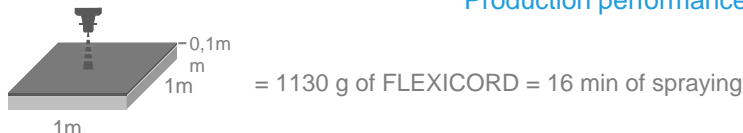


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



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