

Rokide® Rods

Technical Bulletin



ROKIDE® TC (Chrome Oxide) Ceramic Rod for Thermal Spraying

PROPERTIES

- Good Resistance to Mechanical Friction
- Good Abrasion Resistance

AVAILABLE ROD SIZES

- 989100208000 - 1/4" Diameter x 24" Length (6.35 mm x 610 mm)

SPRAY PARAMETERS

Acetylene	Pressure: 15 psi	Ball Height: 60+
Oxygen	Pressure: 90 psi	Ball Height: 90+
Air	Pressure: 80 psi	
Standoff Distance	4 inches (10 cm)	

Rod Type	989100208000 (1/4" X 24")	
Nozzle	987733213000	
	987733279000	
Air Cap	987733281000	
Rod Speed	4 in/min (10 cm/min)	
Lay Down Rate	0.62 Lbs/hr	0.75 Lbs/hr
	(0.28 Kg/hr)	(0.34 Kg/hr)
Deposit Efficiency	55%	51%

APPLICATIONS

- Pump Sleeves
- Pump Shafts
- Impellers
- Casings
- End Plates
- Mud Pump Shafts
- Mechanical Seal Faces
- Valve Stems
- Suction Box Covers
- Oil Seals
- Wire Drawing Capstans
- Wire Draw Blocks
- Sheaves
- Drawing Rolls
- Guides
- Pulleys
- Heat Seal Bars
- Heat Seal Jaws

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PACKAGING

Rod Type	989100208000
Rods Packaged in tubes	100 rods
(3) Tubes per Cardboard Box	300 rods
Bulk shipment – Rocon Drum	1,600 Rods
Tube weight	14 Lbs. (6.3 Kg)

COATING FEATURES

PHYSICAL	
Color	Black
Total porosity	7.9%
Bulk Density	4.0 g/cc
Crystal Phase	Eskolaite

MECHANICAL	
Coating Hardness	793 (Vickers/DPH)
Bond Strength	4186 psi
Sand Blast Penetration	0.0039 Depth/mm
Falex Wear test	6.2 mm ³ /KMS

ELECTRICAL	
Conductivity	Nonconductor

TYPICAL CHEMICAL COMPOSITION (%)

Cr ₂ O ₃	82.98
SiO ₂	8.40
Al ₂ O ₃	3.20
Fe ₂ O ₃	0.78
MgO	2.90
TiO ₂	0.16
NaO ₂	0.28
CaO	1.30

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