

# THERMAL SPRAY FLEXICORD

## Technical Bulletin

# ROCDUR 625

Special alloys series – ref : 98217 6047 000

ROCDUR 625 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 625 provides dense and smooth coating with low porosity. Oxidation resistant. Best corrosion-resistance coating among all Flexicord products. ROCDUR 625 withstands many corrosive environments: alkaline, sea water. Low residual oxidation after spraying. Nonmagnetic. Ideal material for temperature ranging from cryogenic to 1093°C (2000°F). Can be finished by bead blasting to reduce Roughness Ra and to seal the surface.

### Applications

Protection of boiler tubes, parts subjects to sea water corrosion, section of waste energy plants.

### Typical composition (%) - T<sup>TIP</sup>

Ni Cr Mo Fe alloy

### Color code

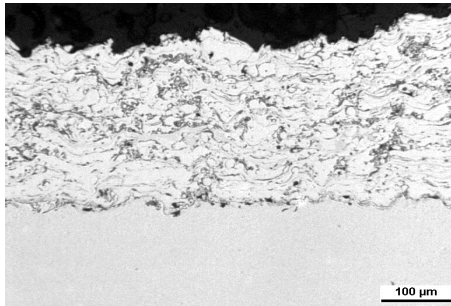
Skin Red

### Packaging

Ø Flexicord 4,75 mm  $\pm$  0,1mm

Spool Plastic - SD 300mm

Weight 8 Kg  $\pm$  10%



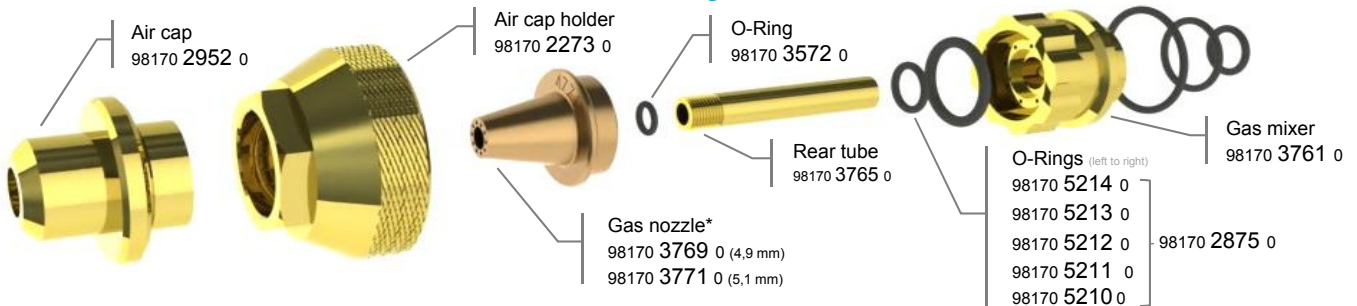
Typical microstructure of RocDur 625 sprayed with our Master Jet® flame spray gun.

### Coating features

Porosity	2 – 5%
Pore diameter	5 – 10 µm
Roughness Ra (as sprayed)	6 – 8 µm
Hardness	340 Hv <sub>300</sub>
Density	8,44 g/cm <sup>3</sup>
Deposit Efficiency	80%
Melting point	1350°C (2460°F)

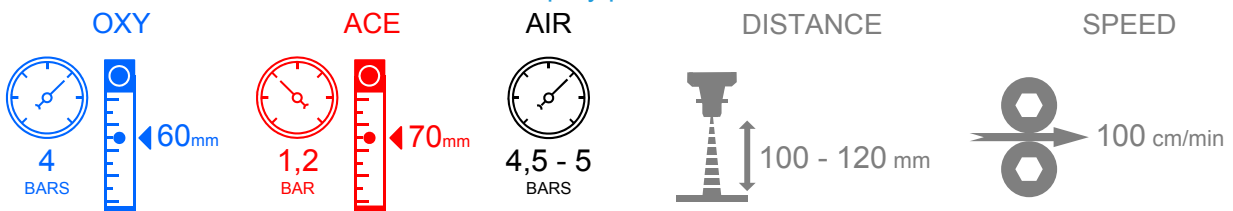
Similar composition to Inconel® 625\*

### Gun configuration

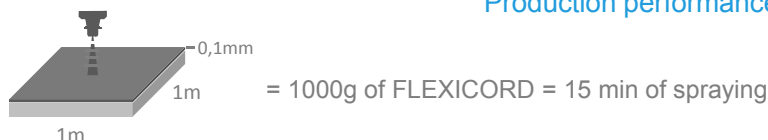


\*Use 4,9 mm in dry area – 5,1 mm in wet area

### Spray parameters



### Production performances



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