

THERMAL SPRAY FLEXICORD

Technical Bulletin

ROCDUR 29

RocDur series – ref : 98217 3147 000

ROCDUR 29 Flexicord is designed to be sprayed (with our MASTER JET® flame spray gun) and fused. ROCDUR 29 provides medium wear resistant coatings as well as a good thermal aging resistance and low cracking occurrence at post fusion. Very good resistance to thermal shocks. ROCDUR 29 can also be used as a bond coat for ROCDUR 6750/6740.

Applications

Glassworks components (molds, press and blow plungers...), wide and/or concave surfaces, highly thermally stressed, mechanical parts rebuilding, corrosion resistant coatings, can be used as a bond coat for RocDur 6750 and RocDur 6740. Post fusion only with acetylene.

Typical composition (%) - TTIP

Ni 1,8B 2,7Si 0,8Fe 0,06C

Color code

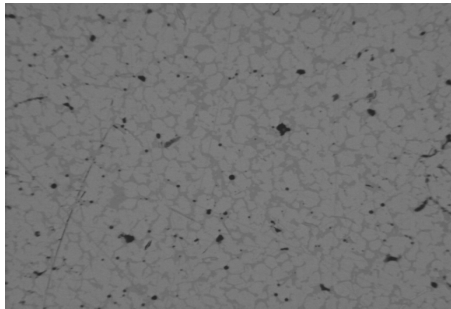
Skin Red

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,5 Kg +/- 10%

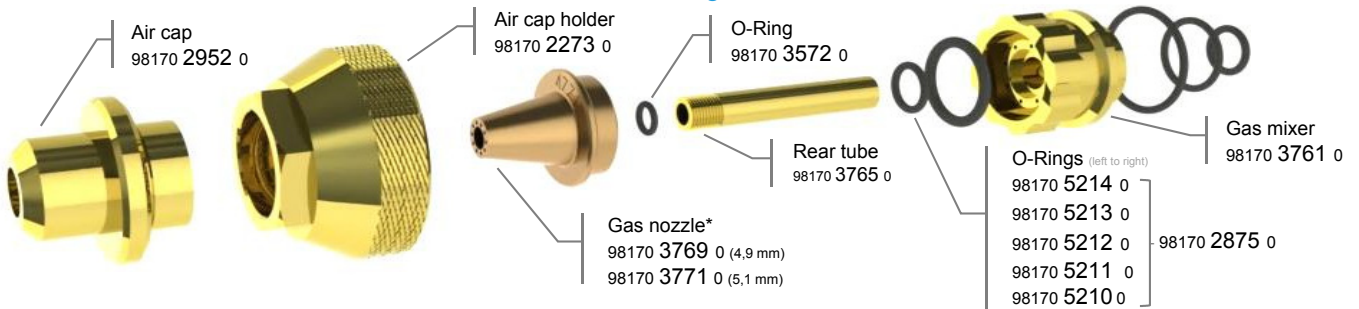


Typical microstructure of RocDur 29 sprayed with our Master Jet® flame spray gun and fused.

Coating features

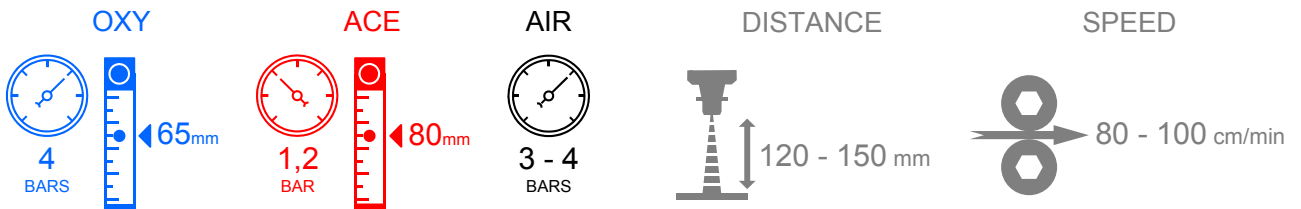
Porosity	< 1% as fused
Pore diameter	< 1 µm as fused
Roughness Ra (as sprayed)	12,5 µm
Hardness (after fusion)	210 – 275 Hv ₃₀₀
Density	8,1 g/cm ³
Deposit Efficiency	83% to 90%
Melting point	~1030°C (1870°F)

Gun configuration

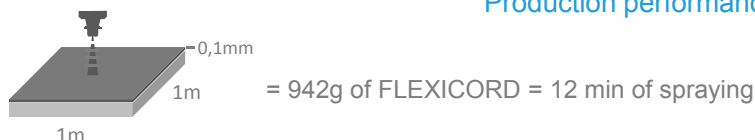


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



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