

THERMAL SPRAY FLEXICORD

Technical Bulletin

ROCDUR 44

RocDur series – ref : 98217 2147 000

ROCDUR 44 Flexicord is designed to be sprayed with our MASTER JET® flame spray gun. ROCDUR 44 provides medium wear resistant coatings as well as a good friction properties. Made of fine particles, it provides smoother & denser coatings than the other RocDur in the as-sprayed state. It produces coating quality close to plasma/HVOF coatings, easy to polish after spraying. Ideal for base coat prior to fluoropolymer top coats. Narrow spray pattern.

Applications

Transfer chutes for glass gob, base coating for polymer (PTFE, FEP, PFA...), friction wear metal surface.

Typical composition (%) - TTIP

Ni 7,5Cr 1,6B 3,5Si 2,5Fe 0,25C

Color code

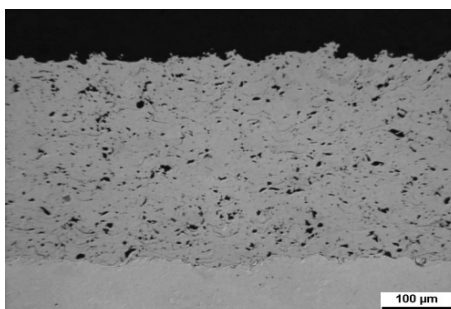
Skin Red

Packaging

Ø Flexicord 4,75 mm +/- 0,1mm

Spool Plastic - SD 300mm

Weight 11,4 Kg +/- 10%

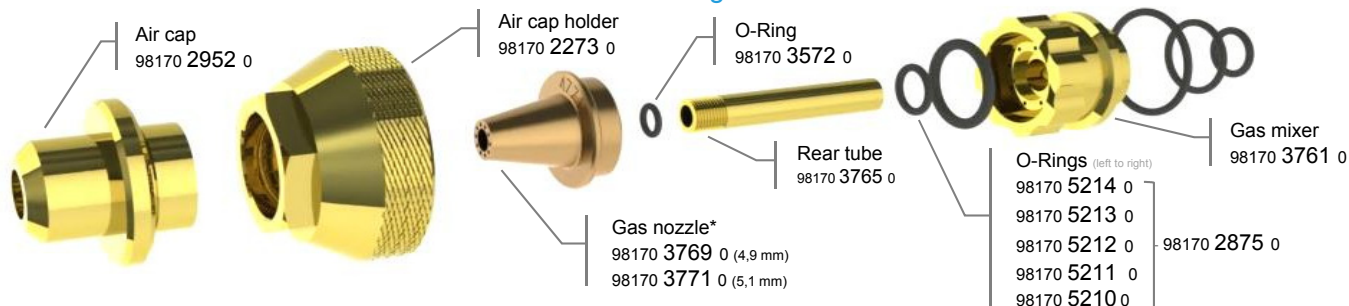


Typical microstructure of RocDur 44 sprayed with Master Jet® flame spray gun.

Coating features

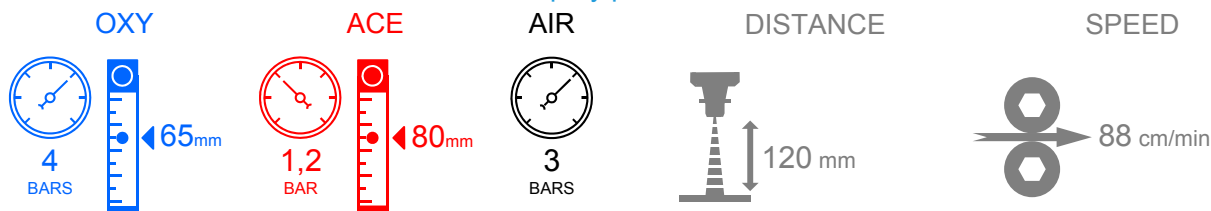
Porosity	2 – 3,5 %
Pore diameter	5 – 15 µm
Roughness Ra (as sprayed)	6 µm
Hardness	370 Hv ₃₀₀ (38 HRC)
Density	8,1 g/cm ³
Deposit Efficiency	75% to 80%
Melting point	~1030°C (1870°F)

Gun configuration

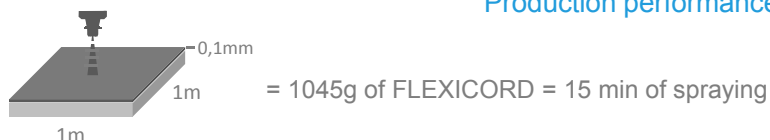


*Use 4,9 mm in dry area – 5,1 mm in wet area

Spray parameters



Production performances



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