

CORODUR® SP 228

Ni-Cr-B-Si- flux cored wire alloy with about 10– 15% primary carbides. High wear resistance against abrasion and corrosion, e.g. for components loaded by chemical fluids containing abrasive particles. Can be sintered (self-fluxing). Made exclusively for arc spraying, but may also be sprayed by wire- and high-velocity-wire-flame-spraying.



Typical applications are as bond coat and for repair in chemical industry, petro chemical industry and for off-shore and mining machinery applications such as plungers and shafts.

COMPOSITION (WEIGHT-%)

Base = Ni

Cr	Si	B	Sc	C
25,0	<4,5	2,0	15,0	0,4

Hardness
HV 0,1

800-1000

Melting point
°C

1300

Density
g/dm³

7,2

Spray rate
kg/h/100 A

4,5

SPRAY PROCEDURE (Arc)

Standard mm	Atomizing Air Pressure	Arc Load Volt	Amperage Ampere	Stand off mm	Thickness/ pass mm/Pass	Efficiency %
1,6	3,5	29-32	200-300	125-175	0,125	70-80

UNIT

Coil

B5 300 = 15 kg

B 450 = 25 kg

Wire Diameter

1,6 mm (1/16")

2,4 mm (3/32")

