

## Classifications

EN 14700	EN ISO 14232-1
P Z Ni3	Ni-SF40 - 125/45

## Properties

The deposit is resistant against oxidation, heat and corrosion, also against dilute sulphuric and other acids. Also resistant against medium shock. Homogeneous deposit free of porosity. Polishable.

## Application field

For cylindrical parts, such as shafts, sleeves, plungers. Particularly suited for the glass industry and for all applications where a medium hard deposit with good resistance against metal-to-metal wear is requested. Applicable on steel, cast steel and cast iron.

## Chemical composition in %

C	B	Cr	Si	Fe	Ni
0.25	1.6	7.5	3.5	2.5	Balance

## Technical Data (Typical values)

Particle shape	spherical
Grain size range	-125 µm + 45 µm
Apparent density (ISO 3923–2) (g/cm <sup>3</sup> ) typical	4.6
Hall flow (ISO 4490) (s/50g) typical	14
Hardness (matrix):	38 – 42 HRC
Recommended coating thickness	max. 3.0 mm (max. 1.0 mm per step)
Melting point (matrix)	1050 °C
Powder consumption per 0.1 mm coat thickness	approx. 0.85 kg/m <sup>2</sup>
Flame adjustment	neutral

## Surface Preparation

The surface to be covered must be metallic clean and free of oil, grease and dust. Machining of the surface as per usual practice. Grit blasting with e.g. electro corundum or silicon carbide (quod vide DIN EN 13507 "Pre-treatment of surfaces of metallic parts and components for thermal spraying").

## Recommendation for machining

Machining with tungsten carbide tipped tools. Grinding with silicon carbide wheel.