



CEWELD Powder

86104-CoCr-45

TYPE CEWELD 86104-CoCr-45 is an agglomerated and sintered tungsten carbide-cobalt-chrome powder specifically designed for HVOF Thermal Spraying.

APPLICATIONS CEWELD 86104-CoCr-45 is for wear resistant coatings produced by flame-, plasma or High-Velocity-Flame-spraying (HVOF). It should be used where added corrosion protection is required versus CEWELD 8812-Co-45 coatings. It has proven to be an excellent alternative to hard chromium plating. Compressor shafts, pump seals, flap actuators, paper rolls, ball valves, hydraulic rods, slush pump piston rods, corrugating rolles, hydroturbine buckes, hardchrome replacement.

PROPERTIES The CEWELD 86104-CoCr-45 HVOF-sprayed, very dense coatings can be achieved with extreme hardness of 800-1300 HV0.3 and adhesion strength of more than 70 MPa. In comparison to WC-Co, coatings from CEWELD 86104-CoCr-45 show a higher resistance against oxidation and corrosion in aqueous solutions and can be operated up to maximum 650°C (1202°F). Primary WC carbide size: 2.5 µm FSSS Apparent density (ISO 3923-2) 5.2-5.8 g/cm³ Particle shape: preponderantly spherical Coating microhardness: 800-1300 HV0.3 Sales units: Particle size* (DIN EN 1274 3.3): -45+22 µm (*other sizes on request) -38+15 µm -25+10 µm

CLASSIFICATION EN ISO 14232-1 WC-Co-Cr 86/10/4

SUITABLE FOR Compressor shafts, pump seals, flap actuators, paper rolls, ball valves, hydraulic rods, slush pump piston rods, corrugating rolles, hydroturbine buckes, hardchrome replacement.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Cr	Co	WC
4	10	86

MECHANICAL PROPERTIES

REDRYING Not required

GAS ACC. EN ISO 14175