

1248T

File: 1.9.2.2CH-1248T
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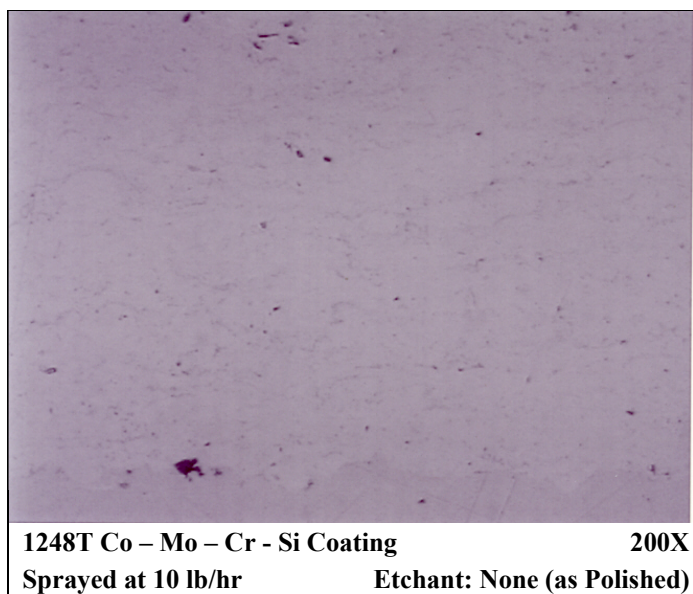
Coating Properties

1248T Cobalt – Molybdenum – Chromium – Silicon (T-800 Type)

Spray Conditions

Excellent coatings of 1248T can be obtained at spray rates of 0.2 up to 4.5 kg/hr (2 -10 lb/hr) with the JP-5000. For typical starting conditions see bulletin 1.9.2.2SH-1248T.

	<u>Spray Rate</u>
	3.0 kg/hr (6.6 lb/hr)
Coverage	78.03 ft ² /hr/0.001” (0.184 m ² /hr/mm)
Powder Required	0.085 lb/ft ² x 0.001” (16.46 kg/m ² x mm)



Coatings (typical):

Thickness (maximum) -		Over 0.050” (1.27 mm)
Finish -	As-Sprayed	150 μ-in AA
	Machined	64 μ-in AA
	Ground	Less than 10 μ-in Ra
	Polished	4 μ-in Ra
Bond Strength -		9,000 psi (Coating failure)
Hardness -	Superficial	90 R _{15N}
	Macro	60 R _C
	Micro	750 DPH _{300g}
Microstructure -	Porosity	Less than 1%
	Oxides	Less than 3%
Coating Density -		7.61 g/cm ³ *

* Calculated Value

Suggested Finishing Procedures:**Grinding**

Wheel:	60 grit Silicon Carbide
Wheel Speed:	5500 – 6500 sfpm
Traverse/pass/rev:	0.080 – 0.170” (2 – 4.3 mm)
Infeed:	0.0005” (0.0127 mm)

The coating data provided herein was generated by skilled operators using equipment in good working condition. The information is believed to be accurate and reliable; however, thermal spray results may vary. Praxair and TAFE is committed to a continuing program of product improvement. Product specifications are subject to change without notice. Praxair and TAFE warrants that the equipment and powder is furnished free of defects in material and workmanship. No other warranty is expressed or implied.

Hazards:

Observe normal spraying practices. Respiratory and hearing protection is advised. For general guidelines see AWS Publication C2.1-73, and AWS TSS-85. Thermal spraying is a safe process when performed in accordance with proper safety measures.

For further information on HVOF coatings, equipment and supplies, as well as other thermal spray processes and custom automated systems, contact:

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