

1260F

File: 1.9.2.2CH-1260F
Issue: P10623
Supercedes: Original Issue

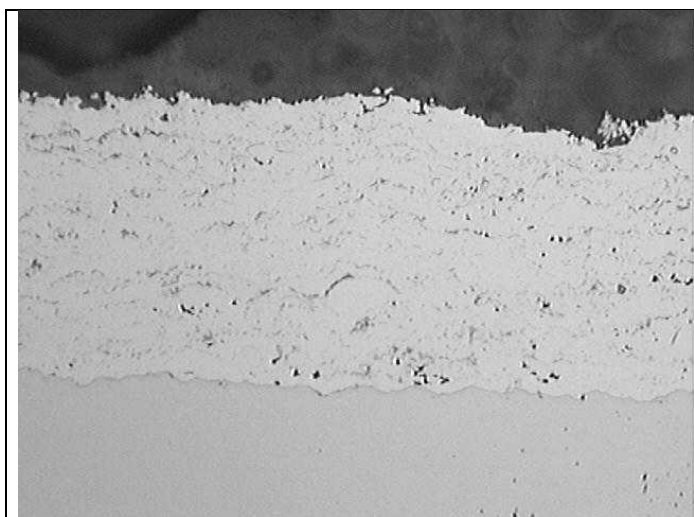
Coating Properties

1260F 50 Nickel – 50 Chromium

Spray Conditions

Excellent coatings of 1260F can be obtained at spray rates of 2 to over 10 lb/hr with the JP-5000. For typical starting conditions see bulletin 1.9.2.2SH-1260F.

	<u>Spray Rate</u>
	10 lb/hr (4.5 kg/hr)
Coverage	125.1 ft ² /hr/0.001” (0.295 m ² /hr/mm)
Powder Required	0.080 lb/ft ² x 0.001” (15.60 kg/m ² x mm)



1260F 50 Ni - 50 Cr Coating **200X**
Sprayed at 10 lb/hr **Etchant: None (as Polished)**

Coatings (typical):

Thickness (maximum) -		Over 0.100” (4 mm)
Finish -	As-Sprayed	260 μ-in AA
	Ground	Less than 20 μ-in AA
Bond Strength -		Over 8,000 psi (Epoxy failure at 0.015” thickness)
Hardness -	Superficial	80-82 R _{15N}
	Macro	40 - 43 R _C (Converted)
	Micro	450 - 480 DPH _{300g}
Microstructure -	Porosity	Less than 2%
	Oxides	Less than 2%
Coating Density -		g/cm ³ *

* Calculated Value

Suggested Finishing Procedures:**Rough Grinding**

Wheel:	60 grit Silicon Carbide
Wheel Speed:	5500 - 6500 sfpm
Part Speed:	25 – 75 rpm
Infeed:	0.0005” (0.0127 mm) (not to exceed)
Method:	Plunge (step) grind to within 0.001- 0.002” (0.0254- 0.05mm)

Finish Grinding

Wheel:	120+ grit Silicon Carbide
Wheel Speed:	5500 – 6500 sfpm
Part Speed:	25 – 75 rpm
Infeed:	0.0002” (0.005 mm) (not to exceed)
Method:	Traverse mode for clean-up of final 0.001 – 0.002” (0.0254 – 0.05 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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