

THERMAL SPRAYING

**UNFORTUNATELY SOME MISTAKES
 HAVE CREEPT IN ON PAGE 9 + 10**

THESE PRODUCTS CAN BE FOUND FROM PAGE 29 ONWARDS

FE-BASIS

Title	Composition												hardness	Features / Application
	Cr %	Ni %	Si %	B %	Mo %	Nb%	Al%	W %	Mn	C	other			
SP 100	17									0,1			30-35 HRC	Repair of machinery components
SP 101	22	0,5		4,5	4,0	3,5		6,5		1,2			68-70 HRC	Friction metal-metal screws, mixers, hot sieves
SP 102	20		1,5	1,5					1,0	0,6	3,5 Ti		850 HV _{0,3}	Abrasion and erosion-resistant to 650 °C, high adhesion
SP 103	25	10	1,2	2	4				1,2	0,5	2 Cu		45 HRC	Polishable, good wear resistance at temperatures up to 370 °C, repair layer
SP 104	21	8	1,1	2,3	3,2				1,2	0,2	2 Cu		53 HRC	Self compacting up to 1000 HV, good grinding, high elasticity, hiss and surface layer
SP 105 HY	20		2,8						11	0,25	11 Co		350 HB	Cavitation-resistant, resistant to erosion, water turbine, hydraulic
SP 106	14	4,5	1,3	1,9				26 WC	0,6		6 TiC		66 HRC	Very good abrasion resistance, anti-slip surfaces in industrial walkways and deck
SP 107	19	8,5	0,4						6	0,1			400 HB	Good corrosion resistance, hardening, good workability, repair layer
SP 108	26	3	1,6		0,8				1,6	1,7			40-42 HRC	Resistant to abrasion, corrosion, easy to work
SP 111	30		1,3	2,8					1,0				40-45 HRC	Low coefficient of friction, chrome replacement coatings, valve stem, plunger, plungers, bearing seats
SP 112	27,5		1,5	3,8					1,5	0,1			1000-1150 HV _{0,1}	Boiler erosion protection, temperature up to 650 °C
SP 113	18	12	0,8		2,7				1,7	0,12			200-240 HV	Comparable to 316L, good corrosion resistance
SP 115	28		1,2						1	5			50-55 HRC	High oxidation and corrosion resistance, high strength, chrome replacement layer, high hardness
SP 118Y	22						5					1 Y	170-270 HV _{0,3}	Good corrosion protection in gas atmosphere to sulfur and carbon, temperature resistant up to 500 °C, good mechanical processability, boiler tubes
SP 120	14	0,4	0,5						0,8	0,35			30-45 HRC	Good corrosion and wear resistance, hard, repair and restoration of machine parts, piston pumps, dispensing areas, rolls, low shrinkage, relatively thick layers

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NI-BASIS

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	Cr %	Si %	B %	W %	Mo %	Nb %	C %	Al %	other		
SP 201	20	4,7	3,2				0,7			500-800 HV _{0,1}	Self-fluxing alloy, subsequently melted down chemical plant, food industry, plunger, piston
SP 206	20	4,5	1,6	2			0,35			500-800 HV _{0,1}	Self-fluxing alloy, subsequently melted down chemical plant, food industry, plunger, piston
SP 211	20	4	4		6	3			< 2 Fe	500-800 HV _{0,3}	Boiler under chlorine atmosphere good corrosion protection, erosion control, use to 450 °C steam temperature
SP 221	20	4,5	0,7		2		0,4			500-800 HV _{0,1}	Biomass boiler A1 + A2
SP 222	20									90 HRB	Adhesive layer in an aggressive environment
SP 223	50									250-280 HV	Good resistance to sulfur at temperatures up to 650 °C, coal plants, black liquor boiler
SP 224	45								1 Ti	32 HRC	Good resistance to S, V in boiler atmosphere at temperatures up to 650 °C, coal plants, pipes, fins walls
SP 225	22				9	3,5	0,05			240-300 HV _{0,1}	Highly corrosion resistant to acids with chlorides, resistant to oxidation and hot gas corrosion, adhesive layer and repair, chemical Industry
SP 226	16			5	17		0,1			200-240 HB	High acid resistance to chlorine, resistant to oxidation and hot gas corrosion chemical, petrochemical, offshore
SP 227	15			3,5	15		0,1			35 HRC	High acid resistance to chlorine, resistant to oxidation and hot gas corrosion chemical, petrochemical, offshore
SP 228	25	0,4	2				0,4		15 SC	700-1000 HV _{0,1}	Hard coating
SP 229								20		55-80 HRB	Dense layers with improved oxidation and corrosion resistance to HT-650 °C, self-adhesive adhesive layer
SP 230								5		65 HRB	Adhesive layer
SP 233								10		65 HRB	Adhesive layer
SP 231					6			5		78 HRB	Exceptional grip by exothermic reaction, for adhesion layers for the repair of machinable carbon steels and corrosion-resistant steels, improved wear resistance by Mo, repairs, storage, good resistance to particle erosion
SP 232	8				5			7	5 Fe	100-120 HRB	For repairs, good machinability corrosion resistant