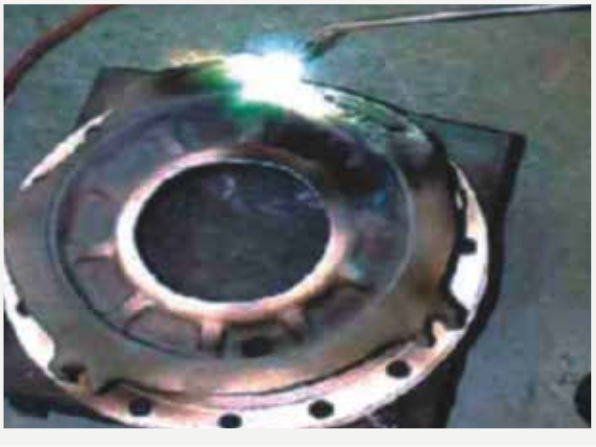
EWAC 1004 EN

Nickel-based Thermal Spray Alloy Powder for Filling, Sealing, Cladding & Joining Cast Iron to Steel

Typical Applications :

Engine blocks, exhaust manifolds, blow holes, differential housings, gears, pulleys, cladding cast iron, glass moulds, etc.



Flange

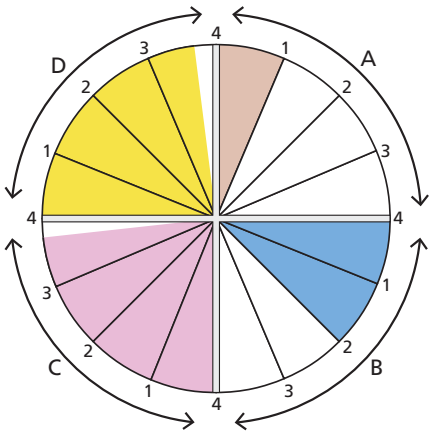
Outstanding Features :

- Very good machinability
- High resistance to impact
- High ductility
- High tensile strength

Procedure:

The surface to be marked is throughly cleaned by grit blasting, grinding or machining to ensure that the workplace is free from all contamination. Preheat the job upto 250° to 300°C. Spray a thin layer of TRIBO PG 07 over the area to prevent oxidation. Heat up to raise temperature between 400° to 700°C to fuse sprayed powder.
Subsequently spray and fuse layers over the entire area to achieve required coating thickness. Take necessary steps to ensure job does not get overheated.

Post cooling, job can be machined to desired dimension.



	A - Abrasion	1
	B - Friction	2
	C - Machinability	3¾
	D - Weldability	3¾

Recommendations :

EWAC 1004 EN has universal use on cast iron. Its outstanding wettability on cast iron makes it ideal for filling, sealing, cladding & joining cast iron to steel. Deposits are smooth, dense and machinable. Excellent ductility and capacity to absorb stress makes it perfect for thin buildups or as a cushion for heavier buildups. Deposits will resist heat scaling, impact and corrosion.

Hardness : 80 - 100 HRb

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