SIMmelt™ NiBas25

Metal flame spray powder

Classifications	
EN 14700	EN ISO 14232-1
P Z Ni2	Ni-SF25 - 106/20

Characteristics

High shock resistance. It resists corrosion and oxidation. Smooth layers, free of porosity. Very good gliding properties.

Field of use

Major applications are building up of badly machined parts and repair of worn out parts such as pressing dies, sliding parts, valve cones, guide wheels, key way edges etc. In glass and machine factories, mining industry etc. Ideally suited on steel, cast steel, grey cast iron and stainless steels. Copper and copper alloys can be built up under reserve.

Chemical composition in %

C	Fe	B	Si	Ni
0.03	0.5	1.3	2.3	balance

Technical Data (Typical values)	
Particle shape	spherical
Grain size range	-106 µm + 20 µm
Apparent density (ISO 3923–2) (g/cm³) typical	5.0
Hall flow (ISO 4490) (s/50g) typical	12
Hardness (matrix):	205 – 260 HV
Recommended coating thickness	max. 5.0 mm
Melting point (matrix)	approx. 1100°C
Powder consumption per 0.1 mm coat thickness	ca. 0.91 kg/m^2
Flame adjustment	neutral

Surface Preparation

The surface to be covered must be metallic clean and free of oil, grease and dust. Machining of the surface as per usual practice. Grit blasting with e.g. electro corundum or silicon carbide (quod vide DIN EN 13507 “Pre-treatment of surfaces of metallic parts and components for thermal spraying”).

Recommendation for machining

Machinable with all common tools. The deposit is polishable.

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.