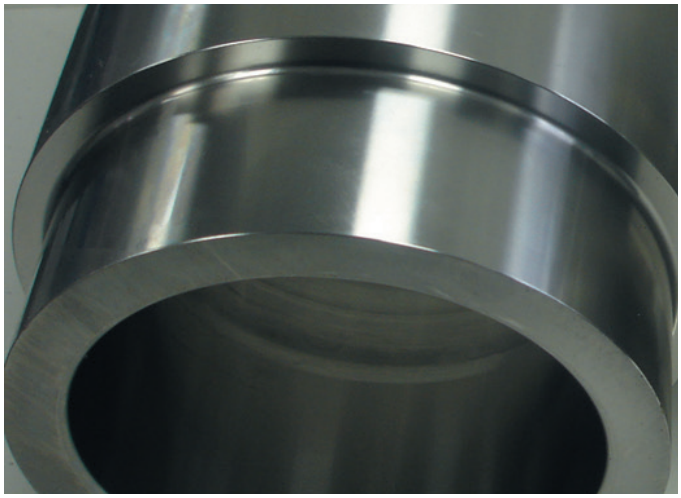
WALLCOLMONOY
SURFACING ALLOYS



Wallex® 12 Cast Guide Bush for Power Plant Applications

Wallex® 12:

A Cobalt-Based Alloy Having High Heat and Corrosion Resistance with Excellent Wear and Abrasion Resistance

Description:

Wallex® 12 is a cobalt-based alloy that has high heat, abrasion and wear resistance. It has low coefficient of friction and is non-galling. It retains high hardness at red heat, and recovers full hardness after exposure to temperatures as high as 1100°C. The alloy has a hardness range of **Rockwell C 43 – 53***.

Its resistance to oxidation, corrosion and erosion is excellent. It is harder and more abrasion resistant than Wallex® 6, but will withstand only moderate shock or impact.

For application involving corrosion plus abrasion, the use of this alloy is particularly economical. It is also used for coating large areas where hair-line cracks would interfere with efficient operation.

Typical applications include:

Guide rolls, bushings, cutting edges of blades, saw tips, veneer pressure bars, control plates and engine valves.

*Typical in the undiluted as-applied and as-cast condition

Nominal Composition - % by Weight:

Co	Cr	W	C	Si	Fe	Others
Bal	29	8.5	1.5	1.5	2.0	Ni, Mo, Mn

Forms Available:

- PTA / Laser Cladding Grade and HVOF powder
- Investment, sand and centrifugal castings
- HIP-consolidated components

Properties:

Table 1: Physical Properties (approximate):

Specific Gravity	8.67
Melting Point	1283°C / 2345°F
Hardness*	43 - 53 HRc

Table 2: Room & Elevated Temp. Typical Hardness:

Hot Hardness °C	Rockwell C
Room	47
400	37
500	37
600	31.5
700	18.5

Application by PTA Welding:

There are numerous Plasma Transferred Arc Welding systems on the market and a wide range of welding parameters can be used with Wallex® 12 to produce excellent weld overlays.

Wall Colmonoy recommends pure argon shielding gas and argon/hydrogen (<5%) plasma/carrier gas. Although, pure argon can also be used as both shielding and carrier/plasma gas.

Welding parameter settings will depend on the base metal, its thickness, geometry and metallurgical condition as well as the desired properties/geometry of the weld overlay and the type of PTA equipment being used.

Preheat and weld inter-pass temperature can affect the quality of the weld deposit and its wear properties.

Preheat Temperature by Class for steels

Class	Description	up to ½"	½" to 1"	1" to 2"	Interpass
10xx	C steels	100 – 600	100 – 700	100 – 800	200 – 700
13xx	Mn steels	350 – 500	400 – 600	450 – 700	450 – 600
23xx	Ni steels	200 – 400	200 – 500	300 – 700	300 – 600
31xx	Ni – Cr steels	200 – 600	300 – 700	400 – 900	>400
32xx	Ni – Cr steels	300 – 900	400 – 1000	500 – 1100	500 – 900
33xx	Ni – Cr steels	500 – 900	600 – 1000	700 – 1100	700 – 900
34xx	Ni – Cr steels	900 – 1100	900 – 1100	900 – 1100	900 – 1100
4140	Cr – Mo steel	600	700	800	600 – 800
4340		600	800	900	700 – 900
46xx		400 – 600	500 – 700	600 – 800	≅ 600
4820		600	700	800	600 – 800
5120		100 min	200 – 300	250 – 350	≅ 300
5145		400 – 500	450 – 550	500 – 600	≅ 500
86xx		100 – 400	200 – 500	300 – 600	≅ 400
High strength alloy steels (quenched and tempered)					
A533, B		50 – 200	100 – 350	200 – 450	100 – 350
A542		150 – 300	200 – 350	250 – 450	200 – 350
HY-130		75 – 225	75 – 275	200 – 375	200 – 350

Application by Laser Cladding

Laser cladding utilises a laser beam as a heat source to weld a surfacing material to a substrate. Surface cladding powder is delivered to the weld zone through a powder feeder with an inert gas carrier. The power level of the laser, the powder feed rate, pre-heat of the base metal, and 3-dimensional movement speeds must be balanced to produce a metallurgically bonded, low dilution, crack free, porosity free clad overlay.

Properly applied laser clad overlays can have significantly higher hardness than a corresponding thermal spray applied coating of the same material. Alloy selection for the laser cladding process should take this into consideration.

Laser cladding can be conducted in a sealed, inert environment, or in an open shop environment. In the latter case, the use of argon or helium carrier gases with argon and/or helium shielding gases are recommended. Nitrogen is not an inert gas and it is not recommended for general use in laser cladding.

Machining, Grinding and Lapping:

There are several techniques used for material removal that produce high quality finished products. Machining can be done, using cubic boron nitride tooling. Use GE's BZN compacts (such as BRNG-43T) or Kennametal's CNMA 433KC-210. Use a negative rake tool, with a 15-degree lead angle. It should have a 1.2mm (3/64-in.) radius and T-land edge preparation. Set tool at centreline of work. Feed at 0.005-0.010 IPR, with depth of cut up to 3.2mm (0.125-in.), at 200-300 SFM or higher.

The coatings can be machined with difficulty by carbide-tipped tools, such as Kennametal K6, Carboloy 883 or equivalent. For roughing, grind the tool with a slight lead and rake angle, and a slight radius (approx. 0.8mm (1/32")). Use a fine feed, about 0.076mm (0.003") per revolution, with a depth of cut about 0.38mm (0.015") at 15 SFPM. Set tool about 0.8mm (1/32") below centre. For finishing, grind the tool with the same slight lead and rake angles and with about a 1.6mm (1/16") radius. Use a fine feed, about 0.076mm (0.003") per revolution, with a maximum cut of 0.13mm (0.005") at approximately 45 SFPM.

Grinding is used after machining to remove the last 0.13 – 0.15mm (0.005-0.006") of material. Actually, the entire finishing is most commonly done by grinding, which eliminates machining. Grinding produces a near-frictionless mirror finish.

Such smooth surfaces usually wear better, because they generate less heat and friction. Whereas a diamond wheel is preferred, green silicon carbide wheels (hardness H to K) can be used. Use 24 to 36 grit for roughing and 60 grit or finer for finishing. Grind wet when possible; do not let the wheel get loaded; dress frequently. Take light, fast cuts. (Manufacturer can provide full details for grinding.)

Safety:

When handling powders do so in such a way to avoid creating a dust cloud; avoid inhalation or contact with skin or eyes. Conduct coating operations in a properly ventilated area. For more information, consult 11.8 (Ventilation), AWS Thermal Spraying: Practice, Theory, and Application available from American Welding Society, OSHA Safety and Health Standards available from U.S. Government Printing Office, and the manufacturer's Material Safety Data Sheet (MSDS).

Warning: Thermal spray torches and heating torches used for application of this product utilize compressed gases including oxygen and a flammable fuel gas. Follow your employers safety procedures when using and handling these gases and equipment. Infrared and ultraviolet radiation (light) emitted from flame and hot metal can injure eyes and burn skin. Use appropriate personal protective equipment.

Danger: Plasma transferred arc (PTA) welding is a welding process used for application of this product. Follow your employers safety procedures and the equipment manufacturers instructions when PTA welding. Electric shock can kill. Properly install and ground electrical equipment prior to use. Infrared and ultraviolet radiation emitted from the hot metal or welding arc can injure eyes and burn skin. Use appropriate personal protective equipment.

Warning: Laser cladding processes may use high power levels when applying this product. Follow your employers safety procedures and the equipment manufacturers instructions when laser cladding. Refer to AISI Z136.1 "Safe use of Lasers" and consult your employers Laser Safety Officer regarding the proper use of personal protective equipment.

Storage Requirements:

Keep thermal spray powders in a closed container and protect against moisture pick-up. The containers should be tumbled before using the powder. If moisture is absorbed from the atmosphere, it can be removed and flowability can be restored by drying the powder, with the seal removed and lid loosened, at 66°C – 93°C (150-200°F) for two hours prior to use.

The information provided herein is given as a guideline to follow. It is the responsibility of the end user to establish the process information most suitable for their specific application(s).
Wall Colmonoy Limited (UK) assumes no responsibility for failure due to misuse or improper application of this product, or for any incidental damages arising out of the use of this material.

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