



Photomicrograph of PTA welded Colmonoy® 7303-65P4
(original at 100x)

Colmonoy® 7303-65 Alloys:

(7303-65P4, 7303-65P5)

A Nickel-Based Hard-Surfacing Composite Alloy for High Impact and Wear Resistance in PTA Applications

Description:

Colmonoy® 7303-65 alloys include 7303-65P4, and 7303-65P5. These alloys are for application by the PTA Welding and Laser Cladding processes

Colmonoy® 7303-65 alloys are a composite blend of atomized nickel-based alloy powder and 65% by weight monolithic tungsten carbide. The combination of an extremely tough matrix and very hard carbide produces an exceptional impact and wear resistance combination. A dense carbide distribution with small inter-carbide spacing allows for a large surface area of tungsten carbide to be exposed to the wear environment to provide maximum service life.

The monolithic tungsten carbide particles with ~6.1% carbon retains their structure better than traditional cast tungsten carbides. More heat can be absorbed prior to the phase transformation to liquid; therefore less dissolution of the carbide occurs. The monolithic tungsten carbide can better withstand the temperatures associated with high amperage PTA welding processes and resist degradation. The matrix hardness of Colmonoy® 7303-65 alloys is typically **Rockwell C 30-40**.

Colmonoy® 7303-65 alloys are typically used on mining and drilling equipment, impact hammers, earthmoving and aggregate processing equipment and die plates. Not recommended for applications

where the abrasive particles are extremely fine (less than 5 µm).

Nominal Composition - % by Weight:

Colmonoy® Alloy	B	C	Cr	Fe	Si	W	Ni
7303-65P4 7303-65P5	0.4	4.0	2.1	0.6	1.5	59.0	Bal

Forms Available:

Colmonoy® 7303-65 alloys are supplied as powder for application with PTA and Laser cladding systems.

Alloy	Mesh Size	Application
Colmonoy® 7303-65P4	150 - 45 µm - matrix 150 - 63 µm - carbide	PTA or Laser
Colmonoy® 7303-65P5	180 - 63 µm - matrix 150 - 63 µm - carbide	

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 Colmonoy® 7303-65PTA to produce excellent weld overlays.

Wall Colmonoy recommends that a pure argon plasma gas be used in combination with an argon hydrogen shielding gas and an argon carrier gas.

Actual 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

This nickel-based matrix is tough and does not undergo complex volumetric changes that are cooling rate dependent. However, depending on the type of steel the base metal may transform. Adjustments can be made to preheat, inter-pass and post weld heating temperatures to prevent or minimize stress cracks if desired. (Consult [Technical Services](#) for further details).

Application by Laser Cladding:

Laser Cladding utilizes 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:

If finishing is required Grinding is recommended. 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 and do not let the wheel get loaded; dress frequently. Take light, fast cuts. (Manufacturer can provide full details for grinding.)

Dry lapping can be used to give the alloy an excellent finish. Silicon carbide, boron carbide and diamond dust are all capable of cutting the Colmonoy® coating, but they must be embedded in a cast iron or steel wheel to properly lap fused deposits of Colmonoy® 7303-65 alloys. Apply with a steady pressure and avoid overheating. If the lapping compounds are used loose, they will cut the nickel matrix before the chromium carbides, giving the surface an etched appearance.

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).

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 66-93°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 Corporation (USA) 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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