

Nickel-Base Alloy Powder for the Plasma Transferred Arc (PTA) Process

EuTroLoy® 16221



COATING

- Specially developed for the glass mold industry
- Spherically shaped to ensure highest purity
- Resistant to most high pH, wet environments
- Applied with automated processes



DESCRIPTION:

EuTroLoy 16221 is a nickel-base alloy powder developed specifically for coating cast iron parts via the automatic Plasma Transferred Arc (PTA) process. Although developed for use on cast iron glass mold parts, EuTroLoy 16221 is also well suited for use in applications where a high nickel content coating is appropriate. Coatings of 16221 are moderate in hardness and may be machined using conventional production tooling.

The chemistry and particle size of EuTroLoy 16221 is carefully controlled to insure consistent high quality coating properties.

PROCEDURE FOR USE:

For some applications a modest pre-heat may be required. The degree is dependent on the shape and dimensions of the part and the thickness of the deposit. Surfaces should be clean, white metal, with no oxides (rust), dirt, grease, or oil in the coating area.

TECHNICAL DATA:

Nominal Hardness:	HRC 30-32
Density:	0.30 lb/in ³ (8.34 g/cc)
Max Service Temp.:	1,000°F (538°C)
Melting Point:	2050°F (1120°C)
Machinability:	Excellent using conventional tooling
Corrosion Resistance:	Wet, caustic service environments

APPLICATIONS:

- Glass Mold Parts
- Bottoms
- Guides
- Baffles
- Rings
- Buttering Pass
- Valve Seats (Non-Potable Water Service)

EQUIPMENT:

EuTroLoy 16221 powder is made for use in Eutectic's GAP 400, GAP 2001, GAP 3001 and GAP 3002 PTA equipment. Please contact Eutectic to determine which GAP and/or torch equipment is right for your coating needs.

HEALTH & SAFETY:

Observe normal spraying practices, respiratory protection and proper air flow pattern advised. For general spray practices, see AWS Publications AWS C2. 1-73, "Recommended Safe Practices for Thermal Spraying and AWS TSS-85, "Thermal Spraying, Practice, Theory and Application." Thermal spraying is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before starting spray operations. DO NOT operate your spraying equipment or use the spray material supplied, before you have thoroughly read the equipment instruction manual. Refer to the Eutectic web site for Material Safety Data Sheet (MSDS) information.

DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH



Eutectic Castolin develops and manufactures PTA welding units and accessories in various models and sizes either as standard units or as special developments.

Our team of technicians will be able to design with you the cost effective and tailor made solution that fits your specific application. From power source to feed unit, welding torch, even handling devices or robots when required, we take care of all the details.

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Eutectic Corporation
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
P 800-558-8524 • F 262-255-5542
www.eutecticus.com

Eutectic Canada
428, rue Aime Vincent
Vaudreuil-Dorion, Quebec J7V 5V5
Phone: (800) 361-9439
Fax: (514) 695-8793
www.eutectic-na.com

Eutectic Mexico
KM 36.5 Autopista
Mexico-Quertaro
54730 Cautitlan-Izcalli
Estado de Mexico, Mexico
Phone: 011 (52) 55-5872-1111
e-mail: eutectic.mexico@eutectic.com.mx

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