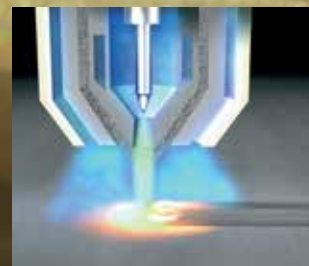




Gas Atomized, Nickel Alloy Powder for the
Plasma Transferred Arc (PTA) Process

EuTroLoy 16495



- Specially developed for the plasma transferred arc process
- Spherically shaped to ensure highest purity
- Consistant powder distribution through equipment
- Abrasion and friction resistant coatings

EuTroLoy 16495

EuTroLoy 16495 is a high performance atomized nickel alloy powder optimized to produce hard, durable, abrasion and friction resistant coatings using the EuTronic® GAP Plasma Transferred Arc Welding Process.

Controlled composition based on AWS A5.13 and precise particle sizing ensures consistent, porosity free weld deposition.

TECHNICAL DATA

Typical Values	
Hardness:	49 HRC
Density:	7.8 g/cc
Hall Flow Rate:	18 seconds
Bulk Density:	4 g/cc

Nominal Composition:

Nickel, Boron, Silicon, Iron, Carbon

Equipment

Made for use in Eutectic's GAP plasma transferred arc equipment. Please contact Eutectic to determine which GAP equipment is right for your coating needs.

PROCEDURE FOR USE:

Grinding Wheel Type:	Green silicon carbide
Grit Size:	60 - 80
Grade:	H (soft)
Structure:	5
Bond Type:	Vitrified
Wheel Speed:	Use manufacturer's recommendation
Work Speed:	50 -65 surface feet per minute

Traverse Speed

Roughing:	5-15 inches per minute
Finishing:	3-8 inches per minute

In-Feed

Roughing:	0.001 inches per pass
Finishing:	0.0005 inches per pass or less

Use flood coolant with rust inhibitors in 2-5% concentration

Notes:

1. Before grinding, all edges and ends of coating must be chamfer ground.
2. Frequently dress the grinding wheel face to reduce friction and heat

TYPICAL APPLICATIONS

- Wash pipes (petroleum drilling)
- Guide plates
- Trimming dies
- Auger flights
- Pistons
- Hydraulic cylinders

To ensure a safe work environment observe normal welding practices, provide appropriate eye, hearing, skin and respiratory protection and pay attention to air flow patterns. For general weld practices, refer to ANSI Z49.1:2012 - "Safety in Welding, Cutting, and Allied Processes". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before starting operations. DO NOT operate your equipment or use the material supplied, before you have thoroughly read the equipment instruction manual. Contact Eutectic for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH.



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