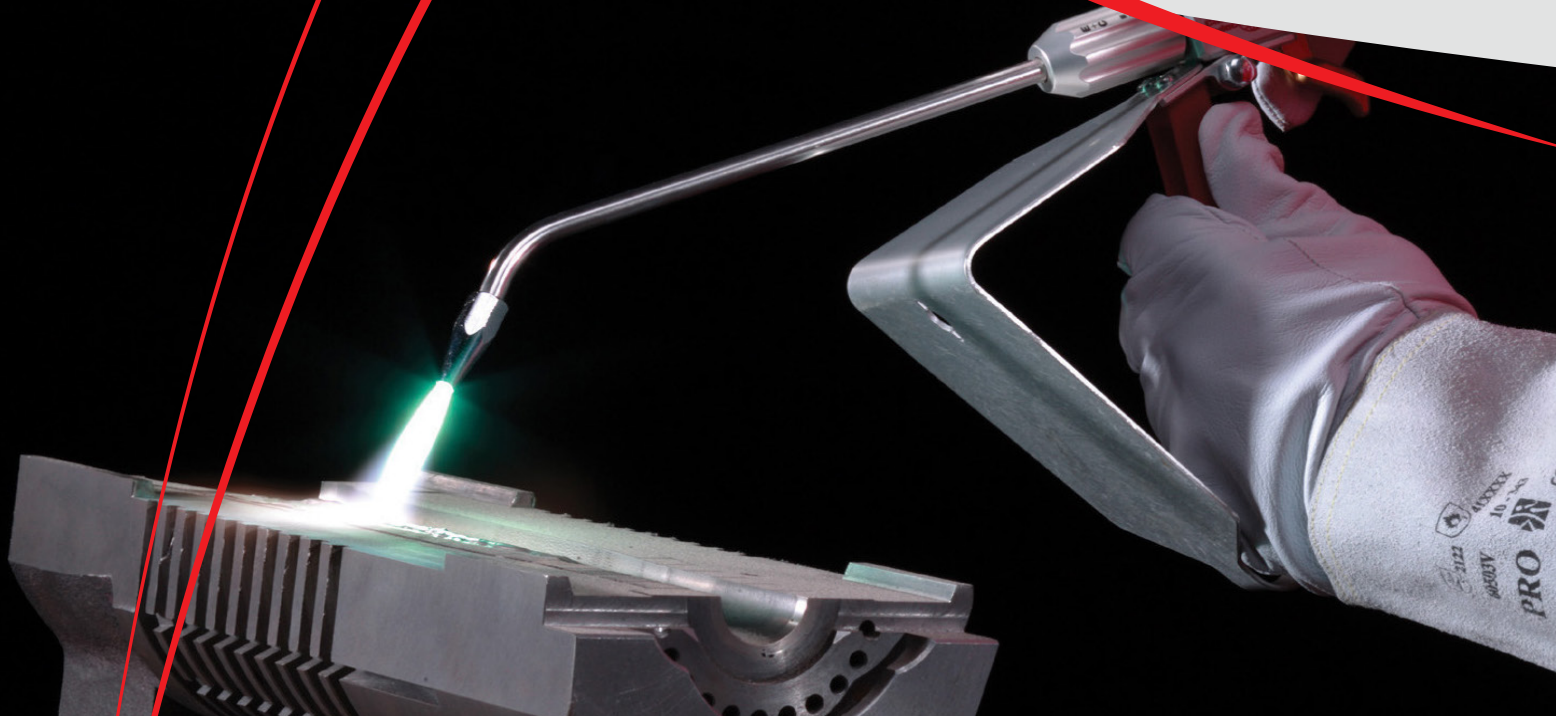




Nickel-Based Alloy Recommended
as a Build-up on Cast Iron Parts

Eutalloy®

11490



- Ideal for protective coating, joining and cladding applications
- The deposit is easy to machine with standard cutting tools
- Exceptionally heat resistant
- Easy build-up on cast iron parts

Eutalloy® 11490

11490 is a nickel base alloy powder designed to provide easy build-up on cast iron parts and excellent machinability. Machined deposits are bright and porosity free. The hardness of this alloy promotes good edge integrity while not detracting from its machinability. The high compressive strength of this alloy resists deformation at elevated temperatures. The Eutalloy process permits precise deposition of 11490 so that thin, tough overlays can be applied and dimensional tolerances maintained.

TECHNICAL DATA

Typical Powder Properties	
Nominal Composition:	Nickel, Balance Boron & Silicon
Hall Flow Rate:	14 seconds
Bulk Density:	4.8 g/cc
Typical Coating Properties	
Hardness:	HRB 95
Maximum Service Temperature:	1200°F (649°C)
Thickness Limit:	None

PROCEDURE FOR USE

Finishing Procedure:

Grinding Wheel Type: Green Silicon Carbide
Grit Size: 60 - 120
Grade: H (soft)
Structure: 5
Bond Type: Vitrified
Wheel Speed: Use Manufacturer's Recommendation
Work Speed: 50 - 65 surface feet per minute

	Traverse Speed	In-Feed
Roughing	5 - 15 inches per minute	0.001 inches per pass
Finishing	3 - 8 inches per minute	0.0005 inches per pass or less

Coolant: 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

General purpose build-up and dimensional restoration for cast iron and steel parts such as:

- Gears
- Patterns
- Templates
- Shafts
- Clutches

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 T55-85, "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 website for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH.



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

