



Atomized Austenitic
Stainless Steel Alloy Powder

Eutectic[®]

29011



- Two-step “Cold Process” powder
- Excellent resistance to atmospheric corrosion
- Precise particle sizing ensures coating consistency
- Good machinability

Eutectic® 29011

29011 is a water atomized austenitic alloy powder designed for use with the TeroDyn® System 2000. It is a Two-Step "Cold Process" powder which must be used in conjunction with a bond coat powder such as 50000 or 21031. Controlled composition is based on 316 stainless steel. Precise control of particle size and chemistry ensure that coatings will offer excellent resistance to atmospheric corrosion, and have a low coefficient of friction and good machinability.

TECHNICAL DATA

Coating Properties	
Typical Macro-Hardness:	Rockwell B Scale, 90
Typical Density:	7.0 g/cc
Thickness Limit:	0.075 inches
Max. Service Temperature:	1000°F (538°C)
Corrosion Resistance:	For immersion service a coating sealer is recommended.
Contact Technical Services to discuss your application (800) 558-8524	
Hall Flow Rate:	30 seconds
Bulk Density:	2.7 g/cc
Powder Coverage:	0.042 lbs/ft² @ 0.001"

PROCEDURE FOR USE

Single Point Turning

(Do Not use coolant unless coating is sealed)

Tool: Carbide, ISO K01
 Rake Angle: -5°
 Turning Speed: 100 SFPM
 Cross-Feed: 0.002 - 0.007 inch/rev
 Work Speed: 50-65 surface feet per minute
 Coolant: Flood coolant with rust inhibitors in 2-5% concentration

	In-Feed
Roughing	0.01 - 0.04 inch
Finishing	0.002 - 0.005 inch

Grinding

(Do Not use coolant unless coating is sealed)

Wheel Specification: 11 C 80 F 13 V Pmf (for 16" wheel)
 Wheel Speed: 5000 - 6000 RPM

	In-Feed	Cross Feed
Roughing	Generally less than 0.005"; operator experience should guide this operation.	75% of the wheel width per revolution of workpiece.
Finishing	Should never exceed 0.001 to 0.002 inches	12.5% of the wheel width per revolution of workpiece.

Recommended Parameters

TD 2000

Nozzle: RL 200
 Module Adaptor: Yellow/Red
 Oxygen: 50 psi / 30 flow (FM-1 flowmeter)
 Acetylene: 12 psi / 60 flow (FM-1 flowmeter)
 T-Valve Setting: 18 clicks
 Spray Rate: 15.0 lb/hr
 Spray Distance: 5 to 7 inches

TYPICAL APPLICATIONS

- Valves
- Shafts
- Armatures
- Packing Glands
- Pistons
- Rolls
- Sleeves
- Seal Areas
- Chemical Process Parts
- Journals
- End Bells

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.



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