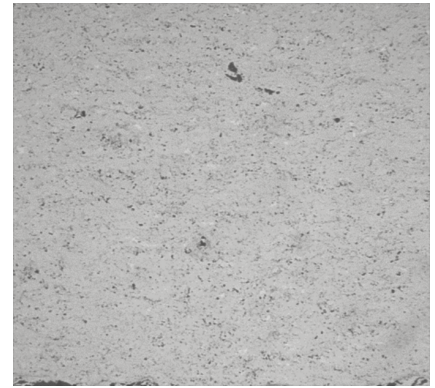


OVERVIEW

CT2250-2 is a Tungsten Carbide Chrome Carbide Nickel coating applied using the HVOF process. The coating is very dense, very hard, very well bonded and suitable for use in the most aggressive wear environments. CT2250-2 is especially effective in applications where the component is exposed to abrasive media and exhibits more ductility than Tungsten Carbide Cobalt coatings. Use in any acids and alkalis where nickel can be used – avoid nitric acid. Use up to 1350° F.

TYPICAL PROPERTIES

Nominal Composition:	73% WC – 20% Cr ₂ C ₃ – 7% Ni
Bond Strength:	In excess of 10,000 psi
Coating Porosity:	Less than 2%
Coating Hardness:	Vickers 1250-1450
As-sprayed Surface Roughness:	80-200 Ra



FOR THE FOLLOWING APPLICATIONS

CT2250-2 is used for severe service conditions of abrasive wear, hard surface wear, low temperature erosion and fretting. Typical components coated with this coating are paper mill rolls, pulp pumps, slurry pumps, concrete block manufacturing wear parts, mixer blades, etc.

FINISHING

Finish CT2250-2 by diamond grinding. Flood cool with 2% oil solution. For roughing use 150 grit diamond wheels, work rotation should be 400 SFPM, .080" per pass crossfeed, .0005" per pass infeed. Finish with 400 grit diamond wheels, work rotation should be 400 SFPM, .040" per pass crossfeed, .0005" per pass infeed.

Finishes of 2-4 Ra are possible by grinding. This coating may also be superfinished to a 1 Ra finish.

SPECIFICATIONS

CT2250-2 meets the following specifications:

Internal CTS specifications only