

EUTALLOY 10680

Nickel-Based Alloy Recommended For Cast Iron Protection And Repair

DESCRIPTION

Eutalloy 10680 is a premium 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. Deposits will not scale even at elevated temperatures. The Eutalloy process permits precise deposition with a minimal amount of overspray. Thin, tough overlays can be applied and dimensional tolerances maintained.

Eutalloy 10224 is recommended for rectifying both machining and casting defects, as well as for protective coatings against oxidation, with a considerable gain in service life for a number of parts.

Product Details:

- Deposits are easily machinable and porous-free
- Compressive strength resists deformation at high temperatures
- No deposition scaling with increased temperatures
- Precise deposition with minimal overspray

APPLICATIONS:

Deposit Thickness: Unlimited

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

- Gears Shafts
- Patterns
- Clutches

EQUIPMENT:

Eutalloy 10680 may be applied by either the Eutalloy B torch or the UltraJet Eutalloy torch using acetylene as the fuel gas.

PROCEDURE FOR USE:

Preparation:

All surfaces to be coated should be thoroughly cleaned, removing all contaminants, oxides and grease. Thin surfaces and edges require no preheating. However, large, heavy and cast iron parts of all thickness should be heated to about 575°F (approx. 302°C) (blue hot).

Coating instructions:

Adjust the torch flame so that a neutral or slightly carburizing flame is achieved and preheat the surface to approximately 575°F. After depositing a layer of powder, fuse with the torch flame until a glazed appearance is achieved.

Leave the part to cool slowly and away from air currents.

Where possible, place it in vermiculite or cover with a thermal blanket.

TECHNICAL DATA:

Typical hardness: 95 HRB

Tensile Shear Strength: 517N/mm² (75,000psi)

Maximum Service Temperature: 1200°F (649°C)