



Manufacturers of Custom Welding Lines for Resale  
[www.selectrode.com](http://www.selectrode.com)

# SELECTRODE 4009 RC-60 Hard Overlay Hot Spray Powder

## FEATURES & APPLICATIONS

Our code 4009, is a self fluxing nickel-chrome-boron-silicon powder which, when applied with a spray and fuse oxy-acetylene torch, produces dense pore-free, hard, grindable coatings. It will resist wear be it abrasive grains, hard surfaces or particle erosion.

Special gas atomized powders designed for use in all spray and fuse "puddle torches"

- Spherically shaped particles promote excellent powder flow through torch components.
- Custom balanced particle sieve distribution creates the highest powder efficiency with the lowest amount of overspray.

## TYPICAL PROPERTIES

<b>Nominal Chemistry</b>	<b>Cr 15% , Fe 4.5% , Si 4.5% , B 3.5% , Ni Balance Particle Size: -140+325 mesh</b>
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### TYPICAL PROPERTIES:

Melting Temperature: 1875°F (1024°C)

Coating Hardness RC 59-62

Essentially non-porous

Application Brake drums, forging tools,  
exhaust valves and valve seats

4009 coatings produce a metallurgical bond with the substrate and have a smooth texture after fusing. It can be finished to size by grinding only.