



Manufacturers of Custom Welding Lines for Resale
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

Nominal Chemistry	Cr 15% , Fe 4.5% , Si 4.5% , B 3.5% , Ni Balance Particle Size: -140+325 mesh
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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.