



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 4224

RC-10 Machinable Hot
Spray Powder for Cast Iron

FEATURES & APPLICATIONS

Our code 4224 is an extremely fine and pure atomized powder that "wets out" easily on cast irons and steels.

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	C .03% , Si 2.5% , B 1.5% , Fe .9% , Ni Balance Particle Size: -140+325 mesh
--------------------------	---

Melting Temperature: 1875°F (1024°C)
Coating Hardness RC 8-11
Application Best for repair on cast irons and other difficult to "wet" metals.

4224 coatings produce a metallurgical bond with the substrate and have a smooth texture after fusing. It can be finished to size easily by filing or machining.