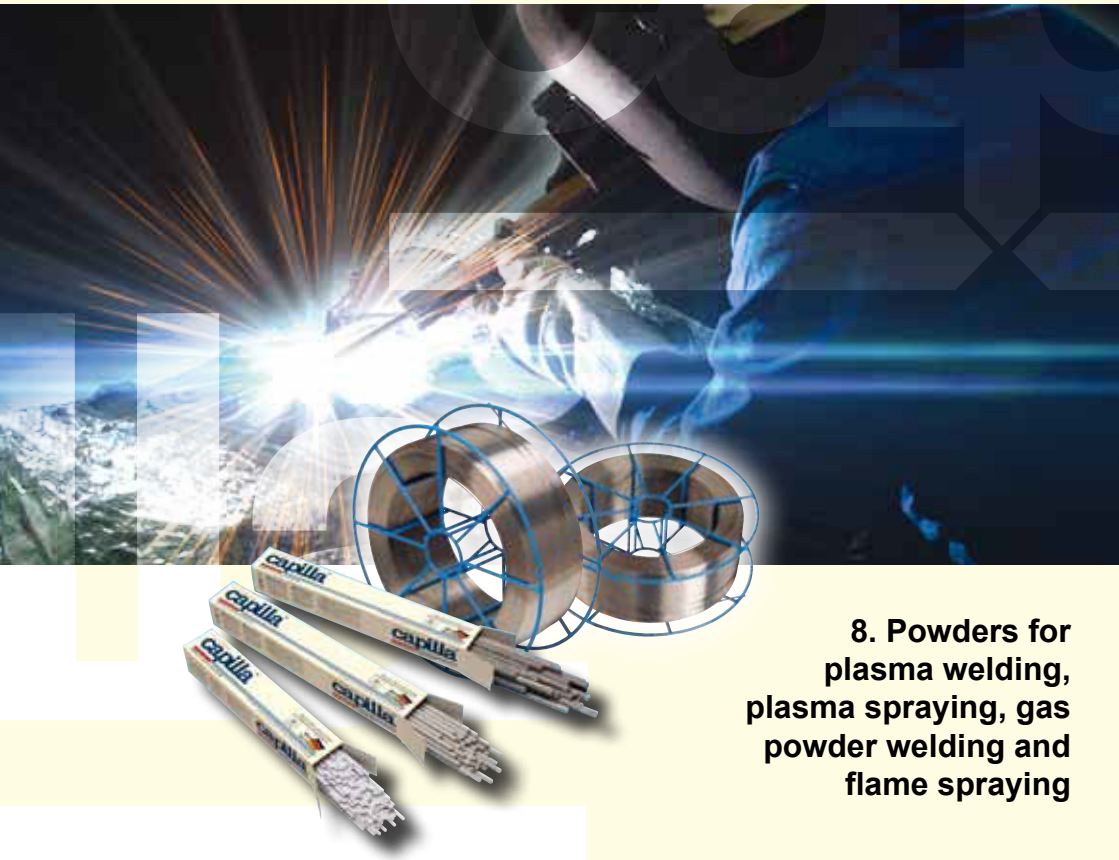
capilla®

Part catalogue



8. Powders for plasma welding, plasma spraying, gas powder welding and flame spraying

8 Powders for plasma welding, plasma spraying, gas powder welding and flame spraying

Designation										
Fe-based	**C**	**Si**	**Cr**	**Mo**	**Ni**	**W**	**B**	**Others**	**Hardness**	**Remarks**
capilla®										
Capidur 4015	0,04	0,7	17	-	-	-	-	Mn = 0,5	20 – 40 HRC	
Capidur 4115	0,2	0,6	17	1,1	-	-	-	Mn = 0,5	30 – 50 HRC	
Capidur 410 NiMo	0,04	0,7	13	0,5	4,7	-	-	-	40 HRC	
Capidur 4031	0,4	0,4	13	-	-	-	-	-	44 HRC	
Capicoat 316 H	0,1	-	17	2,2	13	-	-	-	170 HB	
Capicoat 51	0,08	0,75	19	-	9	-	-	Mn = 7	170 HB	
Capidur 30 FeCrMn	0,12	5	21	-	8	-	-	Co ≤ 0,07; Mn = 6,5	30 HRC	
Capidur 60 FeCr	3,9	-	31	-	-	-	-	-	57 HRC	
Capidur 45 FeCr	2	0,6	31	-	-	-	-	-	43 HRC	
Capidur 65 FeCrNb	5,4	1,4	12	-	-	-	1	V = 6; Nb = 6,5	65 HRC	

Designation										
Ni-based	**C**	**Si**	**Cr**	**Mo**	**Ni**	**W**	**B**	**Others**	**Hardness**	**Remarks**
capilla®										
Capidur 20 Ni	0,05	3	-	-	Bal.	-	2	Fe = 2,5	31 HRC	self-fluxing
Capidur 40 Ni	0,3	3,5	8	-	Bal.	-	1,6	Fe = 3	40 HRC	self-fluxing
Capidur 45 Ni	0,4	3,5	9	-	Bal.	-	2	Fe = 3	45 HRC	self-fluxing
Capidur 50 Ni	0,6	3,8	11	-	Bal.	-	2,5	Fe = 3	50 HR	self-fluxing
Capidur 55 Ni	0,5	3,7	17	4,5	Bal.	-	2,5	Cu = 2	55 HRC	self-fluxing
Capidur 60 Ni	0,8	4,3	16	-	Bal.	-	3,5	Fe = 4,5	60 HRC	self-fluxing
Capidur 35 NiCr	0,05	4,5	33	-	Bal.	-	1,1	Cu = 1,6; Nb = 0,5	34 HRC	self-fluxing
Capidur 40 NiCr	0,1	4,6	36	-	Bal.	-	1,7	Co ≤ 0,07	39 HRC	self-fluxing
Capibond NiAl 5	0,03	-	-	-	Bal.	-	-	Al = 5		adhesion primer
Capibond NiAl 6	1	-	18	-	Bal.	-	-	Al = 6		adhesion primer
Capidur NiCrMo 24/21	0,03	3,40	24	21	Bal.	-	-	Co = 0,07	43 HRC	

8 Powders for plasma welding, plasma spraying, gas powder welding and flame spraying (continued)

Designation										
Ni-based	**C**	**Si**	**Cr**	**Mo**	**Ni**	**W**	**B**	**Others**	**Hardness**	**Remarks**
capilla®										
Capidur NiCrW 26/9	2	-	26	-	Bal.	9	-	-	38 HRC	
Capicoat 5200 S	0,1	0,8	16	16	Bal.	4	-	V = 0,3; Fe = 6	200 HB	
Capicoat 530	0,05	0,4	19	6	Bal.	1		Co = 12; Al = 2,2; Ti = 3	180 HB	
Capicoat NiCr 20	0,1	0,6	20	-	Bal.	-	-	-	170 HB	

Designation										
Co-based	**C**	**Si**	**Cr**	**Mo**	**Ni**	**W**	**B**	**Others**	**Hardness**	**Remarks**
capilla®										
Capidur 506	1,1	-	28	-	-	4,5	-	-	41 HRC	
Capidur 512	1,4	-	30	-	-	8,5	-	-	48 HRC	
Capidur 501	2,4	-	31	-	-	13	-	-	53 HRC	
Capidur R 40 Co	1,2	-	28	3,7	6,5	4,5	-	Cu = 1,6	42 HRC	
Capidur R 40 CoNb	1,6	-	29	3,7	6,5	-	-	Cu = 1,6; Nb = 4	41 HRC	
Capidur R 50 Co	2	-	28	3,7	6,5	10	-	Cu = 1,6	49 HRC	
Capidur R 50 CoNb	2	-	28	3,7	6,5	-	-	Cu 0 1,6; Nb = 5,5	45 HRC	
Capidur 521	0,25	-	28	5	2,8	-	-	-	32 HRC	
Capidur FN	1,6	1	28	-	22	13	-	-	43 HRC	
Capidur F	1,8	-	26	-	23	12,5	-	-	45 HRC	
Capidur 516	0,1	-	20	-	10	15	-	-	230 HB	
Capidur 45 Co	0,8	2,3	19	-	13	8	1,7	Cu = 0,6; Fe = 3	45 HRC	self-fluxing
Capidur 50 Co	0,2	3,5	18	6	27	-	3	-	50 HRC	self-fluxing
Capidur 55 Co	1,3	3	19	-	13	13	2,2	Cu = 0,6; Fe = 3	55 HRC	self-fluxing
Capidur 60 Co	1,3	2,8	19	-	13	15	3	-	60 HRC	self-fluxing

8.1 Powders for plasma welding, plasma spraying, gas powder welding and flame spraying [processing]

Designation	Plasma-welding	Plasma-spraying	Gas powder welding	Flame-spraying
Grain size	50 – 160 µm 63 - 200 µm	32 - 106 µm 45 - 125 µm	16 - 63 µm 45 – 90 µm 32 – 106 µm	32 – 106 µm 45 – 125 µm
Fe-based				
capilla®				
Capidur 4015	X	X		X
Capidur 4115	X	X		X
Capidur 410 NiMo	X	X		X
Capidur 4031	X	X		X
Capicoat 316 H	X	X		X
Capicoat 51	X	X		X
Capidur 30 FeCrMn	X	X		X
Capidur 60 FeCr	X	X		X
Capidur 45 FeCr	X	X		X
Capidur 65 FeCrNb	X	X		X
Ni-based				
capilla®				
Capidur 20 Ni	X	X	X	X
Capidur 40 Ni	X	X	X	X
Capidur 45 Ni	X	X	X	X
Capidur 50 Ni	X	X	X	X
Capidur 55 Ni	X	X	X	X
Capidur 60 Ni	X	X	X	X
Capidur 35 NiCr	X	X		X
Capidur 40 NiCr	X	X		X
Capibond NiAl 5		X		X
Capibond NiAl 6		X		X
Capidur NiCrMo 24/21	X	X		X
Capidur NiCrW 26/9	X	X		X
Capicoat 5200 S	X	X		X
Capicoat 530	X	X		X
Capicoat NiCr 20		X		X

8.1 Powders for plasma welding, plasma spraying, gas powder welding and flame spraying [processing] (continued)

Designation	Plasma-welding	Plasma-spraying	Gas powder welding	Flame-spraying
Grain size	50 – 160 µm 63 - 200 µm	32 - 106 µm 45 - 125 µm	16 - 63 µm 45 – 90 µm 32 – 106 µm	32 – 106 µm 45 – 125 µm
Co-based				
capilla®				
Capidur 506	X	X		X
Capidur 512	X	X		X
Capidur 501	X	X		X
Capidur R 40 Co	X	X		X
Capidur R 40 CoNb	X	X		X
Capidur R 50 Co	X	X		X
Capidur R 50 CoNb	X	X		X
Capidur 521	X	X		X
Capidur FN	X			
Capidur F	X	X		X
Capidur 516	X	X		X
Capidur 45 Co	X	X		
Capidur 50 Co	X	X		
Capidur 55 Co	X	X		
Capidur 60 Co	X	X		

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