

**BONDTEC****COLD METALLIZING POWDER****DESCRIPTION**

The **Bondtec cold metallizing process** differs from the hot metallizing process in that it has a much lower heat input; **workpiece temperature should never exceed 260°C (500°F)**. During cooling, the **Bondtec** metallizing powder particles contract and adhere strongly to steel, cast iron, stainless steel, aluminum, brass, bronze and nickel alloys.

PRODUCTS	COMPOSITION	DESCRIPTION
<b>Bondtec B-91</b>	Ni - Al	<b>Very high nickel</b> alloy for applying bonding coat before overlaying. Excellent results on shafts of any size, cylindrical surfaces, bushings, trunnions, etc. <i>Slightly carburizing flame.</i>
<b>Bondtec B-92</b>	Ni - Cr Fe - C - Si	<b>Machinable nickel-chromium</b> base alloy for overlaying parts subjected to frictional wear. Excellent corrosion resistance. Ideal for motor shafts, trunnions, roller pump liners, cylinder piston rods. Superior machinability. <i>Slightly carburizing flame.</i> <b>Hardness : 80 HRB</b>
<b>Bondtec B-93</b>	Ni - Cr - B Fe - C - Si	<b>Nickel-chromium-boron</b> base alloy for hardfacing parts subjected to <b>strong vibrations</b> , corrosion, frictional wear and abrasion. Machinable by grinding only. Ideal for high pressure hydraulics, pistons, pump shafts, cylinders, etc. <i>Slightly carburizing flame.</i> <b>Hardness : 30 - 32 HRC</b>
<b>Bondtec B-94</b>	Cu - Al Fe	<b>Aluminum-bronze</b> alloy for overlaying parts subjected to frictional wear and impacts. Smooth, bright, work hardening, machinable deposit with excellent thermal conductivity. <b>Low friction coefficient</b> . Ideal for pistons, propeller shafts, conveyor shafts, rollers, etc. <i>Oxidizing flame.</i> <b>Hardness : 64 - 66 HRB</b>
<b>Bondtec B-95</b>	Ni - Cr - W Fe - C - Si	<b>Nickel-chromium</b> base alloy containing <b>tungsten carbide particles</b> for hardfacing parts subjected to severe abrasion. Machinable by grinding only. Ideal for shafts, couplings, rollers, etc. <i>Slightly carburizing flame.</i> <b>Hardness (matrix) : 40 - 42 HRC (+WC)</b>
<b>Bondtec B-96</b>	Ni - Cr Fe - Si - Al	<b>Nickel-chromium</b> base alloy for overlaying parts subjected to frictional wear, compression and corrosion. Ideal for rotor, blower and pump shafts and watertight bushings. <b>Recommended for the food industry</b> . Good machinability. <i>Slightly carburizing flame.</i> <b>Hardness : 80 HRB</b>

For more information contact the FSH Welding Canada Technical Department.

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*Specialized welding alloys and technology. For technical assistance or for ordering:*