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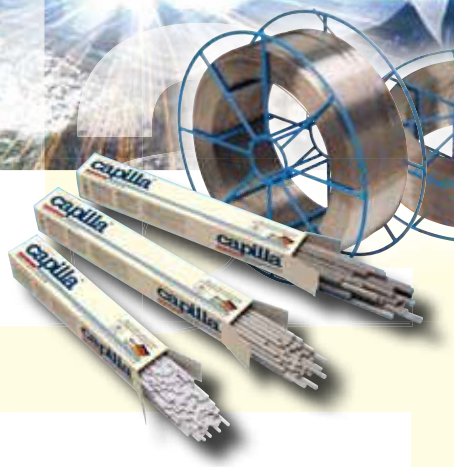


# 8. Материалы для плазменного и газопламенного напыления

## 8. Материалы для плазменного и газопламенного напыления

| 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 HRc | 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 | |

| 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. Порошки для плазменного и газопламенного напыления

| Designation | Plasma-welding | Plasma-spraying | Gas powder welding | Flame-spraying |
|---|---|---|---|---|
| Grain size | 50 – 160 µm<br>63 - 200 µm | 32 - 106 µm<br>45 - 125 µm | 16 - 63 µm<br>45 – 90 µm<br>32 – 106 µm | 32 – 106 µm<br>45 – 125 µm |
| **Fe-based** | | | | |
| **capilla®** | | | | |
| Capidur 4015 | X | X | | X |
| Capidur 4115 | X | X | | X |
| Capidur 4407 | 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 |

| Designation | Plasma-welding | Plasma-spraying | Gas powder welding | Flame-spraying |
|---|---|---|---|---|
| **Grain size** | 50 – 160 µm<br>63 - 200 µm | 32 - 106 µm<br>45 - 125 µm | 16 - 63 µm<br>45 – 90 µm<br>32 – 106 µm | 32 – 106 µm<br>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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