

Nominal Composition (mass %) and Physical Properties

Ni	Cr	Si	B	C	Fe	Others	Hardness
Base	3	2.1	0.8	<0.05	<0.5	2.3%	240-280 HV

Melting Range	880-1000° C	1615-1830° F
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Deposit Density	8.58 g.cm ³	0.310 lb/in ³
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DELORO® 21 is a pre-alloyed gas atomised nickel based powder which is used primarily for the local repair of cast iron glass forming molds, neck rings and blow heads, as well as for hardfacing the corners and seams of molds. It can be used in applications similar to Colmonoy® 224, 225 and 226. It has excellent weld characteristics and is a good color match.

DELORO® 21 is typically deposited as a machinable, non-magnetic powder weld or spray-fuse (SF) deposited overlay. The fusing temperature is 880-940°C (1615-1725°F). It is easily finished by hand filing.

Like the other DELORO® nickel base alloys, its wear resistance is mainly due to the presence of hard boride and silicide phases, and it retains its properties up to about 315°C (600°F). Because of its low melting point it is easily fused to form a smooth hard-wearing surface.

Note: Colmonoy® is a registered trade name of Wall Colmonoy Ltd.

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Literature Number:
DS05-22208 (S0808 R0908)
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Printed in USA
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