



Colmonoy® 6003

An Atomized Nickel-Based
Hard-Surfacing Alloy
to Resist Wear, Corrosion,
Heat and Galling.



A Sucker Rod Coupling Sprayed and Induction Fused.

Description:

Colmonoy® 6003 is an atomized nickel-based alloy, recommended for hard-surfacing parts to resist wear, corrosion, heat and galling. This alloy is designed for spray and fuse applications using combustion thermal spray systems such as those available from Wall Colmonoy - [Spraywelder™ System](#) - and other manufacturers. The lower level of Chromium makes it easier to fuse larger parts. Parts larger than 2 1/2" diameter. Fused coatings are dense, have very low porosity, and are metallurgically bonded to the substrate. Colmonoy® 6003 is spray deposited and fused to achieve a hardness range of **Rockwell C 56 minimum**.

Applications include sucker rods, polished rods and liners, couplings, sinker bars, polished rod clamps, stuffing boxes, pump tees, fracking pump plungers, pony rods, shafts, sleeves, duplex & triplex pump plungers, bushings, seal rings, brick manufacturing equipment, and conveyor screws.

Nominal Composition - % by Weight:

B	C	Cr	Fe	Si	Ni
2.8	0.6	13.0	4.0	4.3	Bal

Forms Available:

Colmonoy® 6003 as supplied is suitable for application with Wall Colmonoy Spraywelder™ System. Other commercially available thermal spray systems may also be used to apply this alloy.

Alloy	Mesh Size	Application
Colmonoy® 6003	125/45 micron	Thermal Spray and Fuse

Colmonoy® 6003:

Colmonoy® 6003 is designed for spray and fuse applications using combustion thermal spray systems such as Wall Colmonoy Spraywelder™ System and Fusewelder™ Torch.

Fused coatings form a metallurgical bond with the substrate providing substrate-to-coating adhesive strength with very low porosity. The coatings show excellent resistance to wear and impact and their hot hardness is good.

Properties:

Table 1: Physical Properties (approximate):

Hardness HV 200g	≥595
Theoretical Density	~7.1 g/cc
Chemical Analysis	API 11B Compliant

Application Methods:

Colmonoy® 6003 is easily applied to all steels having less than .25% carbon, gray cast iron; Meehanite, malleable, ingot and wrought iron; nickel, Monel^a alloy 400, Inconel^a alloy 600, Nichrome, Chromel^b. Most high-temperature alloys can be overlaid without special precautions.

Steel having more than .25% carbon can also be overlaid, but requires controlled slow cooling after fusion, in suitable insulation such as Sil-O-Cel, mica, etc. Do not apply to ferrous metals that require subsequent hardening and tempering, because the dimensional change associated with the formation of martensite will crack the deposits of Colmonoy® 6003. Hardenable base metals may be overlayed, but must be annealed isothermally after uniform austenitizing to prevent cracking of the deposits of Colmonoy® 6003. (Consult [Technical Services](#) for further details).

Application by Spraywelder™:

Colmonoy® 6003 powder is applied by use of the Spraywelder™, which is the recommended Thermal Spray system designed by Wall Colmonoy to produce dense coatings. The powder is sprayed on the part to be hard surfaced as in ordinary metal spraying procedure, and the overlay is then fused to the base metal by torch, induction or furnace. This is ideal when deposits of uniform thickness are being applied over a large area. Reference Spraywelder™ Brochure and Manual for more information.

Machining, Grinding and Lapping:

There are several techniques used for material removal that produce high quality finished products. Machining can be done, using cubic boron nitride tooling. Use GE's BZN compacts (such as BRNG-43T) or Kennametal's CNMA 433KC-210. Use a negative rake tool, with a 15-degree lead angle. It should have a 3/64-in. radius and T-land edge preparation. Set tool at centerline of work. Feed at 0.005-0.010 IPR, with depth of cut up to 0.125-in., at 200-300 SFM or higher.

The coatings can be machined with difficulty by carbide-tipped tools, such as Kennametal K6, Carboloy 883 or equivalent. For roughing, grind the tool with a slight lead and rake angle, and a slight radius (approx. 1/32"). Use a fine feed, about 0.003" per revolution, with a depth of cut about 0.015" at 15 SFPM. Set tool about 1/32" below center. For finishing, grind the tool with the same slight lead and rake angles and with about a 1/16" radius. Use a fine feed, about 0.003" per revolution, with a maximum cut of 0.005" at approximately 45 SFPM.

Grinding is used after machining to remove the last 0.005-0.006" of material. Actually, the entire finishing is most commonly done by grinding, which eliminates machining. Grinding produces a near-frictionless mirror finish. Such smooth surfaces usually wear better, because they generate less heat and friction. Whereas a diamond wheel is preferred, green silicon carbide wheels (hardness H to K) can be used. Use 24 to 36 grit for roughing and 60 grit or finer for finishing. Grind wet when possible; do not let the wheel get loaded; dress frequently. Take light, fast cuts. (Manufacturer can provide full details for grinding.)

Dry lapping can be used to give the alloy an excellent finish. Silicon carbide, boron carbide and diamond dust are all capable of cutting the Colmonoy® coating, but they must be embedded in a cast iron or steel wheel to properly lap fused deposits of Colmonoy® 6003 alloys. Apply with a steady pressure and avoid overheating. If the lapping compounds are used loose, they will cut the nickel matrix before the chromium carbides, giving the surface an etched appearance.

Safety:

When handling powders do so in such a way to avoid creating a dust cloud; avoid inhalation or contact with skin or eyes. Conduct coating operations in a properly ventilated area. For more information, consult 11.8 (Ventilation), AWS *Thermal Spraying: Practice, Theory, and Application* available from American Welding Society, OSHA Safety and Health Standards available from U.S. Government Printing Office, and the manufacturer's Material Safety Data Sheet (MSDS).

Warning: Sprayweld type torches used for application of this product utilize compressed gases including oxygen and a flammable fuel gas. Follow your employers safety procedures when using and handling these gases and equipment. Infrared and Ultraviolet radiation (light) emitted from flame and hot metal can injure eyes and burn skin. Use appropriate personal protective equipment.

Storage Requirements:

Keep thermal spray powders in a closed container and protect against moisture pick-up. The containers should be tumbled before using the powder. If moisture is absorbed from the atmosphere, it can be removed and flowability can be restored by drying the powder, with the seal removed and lid loosened, at 66-93°C (150-200°F) for two hours prior to use.

The information provided herein is given as a guideline to follow. It is the responsibility of the end user to establish the process information most suitable for their specific application(s). Wall Colmonoy Corporation (USA) assumes no responsibility for failure due to misuse or improper application of this product, or for any incidental damages arising out of the use of this material.

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b Registered trademark of Concept Alloys.

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