

AQUADUR M

COATING FOR MOULDS AND CORES

DESCRIPTION

AQUADUR M is a water-based coating with high refractoriness.

Approximate composition: ≈ 67 % refractory fillings (Al- and Mg- silicates, Fe oxide)
 ≈ 6 % organic binder
 ≈ 27 % water

USE

Coating is developed for dipping, pouring and spraying cores produced by processes, such as Croning, Hot box and cold box and for moulds as well.

ACTION

The coating provides compact and robust high fire resistant coatings on the cores, made by using silicone separators as well. It does not form foam when mixing and dilution it. Its sedimentation is very slow after dilutions. The coating produces a smooth surface and it is insensitive to thermo shocks.

PREPARATION

The coating is made in the shape of paste, which must be diluted in two stages before use:

- First we add 10% of water to the paste, then we stir it well to get non-thick paste. The we add another 40 % water and stir it to get coating ready for dipping.
- We stir it with rapidly rotating stirrer. The coating must not contain unbroken aggregates of the paste.

At hot cores, coating must be dried on air. At cold cores, we dry it in dryers or furnaces at temperature fromm 100 do 150 °C.

PACKING

AQUADUR M is packed in plastic buckets at net 25 kg each or in metal container at around 1000 kg each.

STORING AND TRANSPORT

It must be stored in covered stores at 2 to 30 °C. Storing it outdoors is dangerous, because bacterial fermentation can occur. Care must be taken, that the coating does not freeze.

According to the European regulations for international road transport of dangerous goods, **AQUADUR M** is not a dangerous substance.

PROPERTIES

Dry matter content	70 % min
Viscosity after adding 40% of water:	2000 – 3000 cPs