

Marine Applications

Pumps & Motors

Resize bearing diameters
 Repair worn commutators
 Repair impeller diameters



Hydraulics

Repair damaged pistons and rods



Valves

Repair worn/damaged packing area on stems
 Repair damaged seats

Propulsion

Repair/resize worn bearing areas on main propulsion shafts
 Repair worn grounding areas
 Resize bearing saddles and supports
 Repair steam cuts and erosion damage in casing flanges
 Repair damaged or out of tolerance cylinder block liner bores
 Resize out of tolerance crankshaft diameters

Seal Areas

Repair pitting in "O" ring grooves
 Repair damaged flange faces



Applicable Specifications/Process Approvals

AMS 2451
 Mil-Std 2197(SH)
 NAVSEA
 American Bureau of Shipping
 Korean Registry



Typical Deposits Used in Marine Applications

Copper Code 2050
 Nickel Code 2085
 Nickel Code 7280
 Cobalt Code 2043
 Silver Code 3084



Refer To Application Exchanges

95005, 98033, 20109, 20403

- In-Situ Repairs
- Reduce Downtime
- Reduce Teardown & Shipping Costs
- Reduce The Need For Post Plating Machining
- Make Permanent Cost Effective Repairs

Adhesion Of SIFCO Process Deposits

By using ASTM C633-79 Standard Test Method for Adhesion or Cohesive Strength of Flame Sprayed Coatings, SIFCO ASC established values for adhesion of SIFCO Process deposits which indicate that the cohesive strength of the deposit exceeds that of the cement. For example, the minimum tensile strength value established (at the point of cement failure during testing) for Nickel High Speed is 22,803 kPa (11,200psi) on a SAE 4130 steel base material.

Additional qualitative tests, as described in QQN 290 were conducted in which the plated areas were subjected to high stresses and strains. These tests consisted of compressive and tensile bend tests as well as chisel tests into the deposit. The results showed excellent adhesion to the base material.

