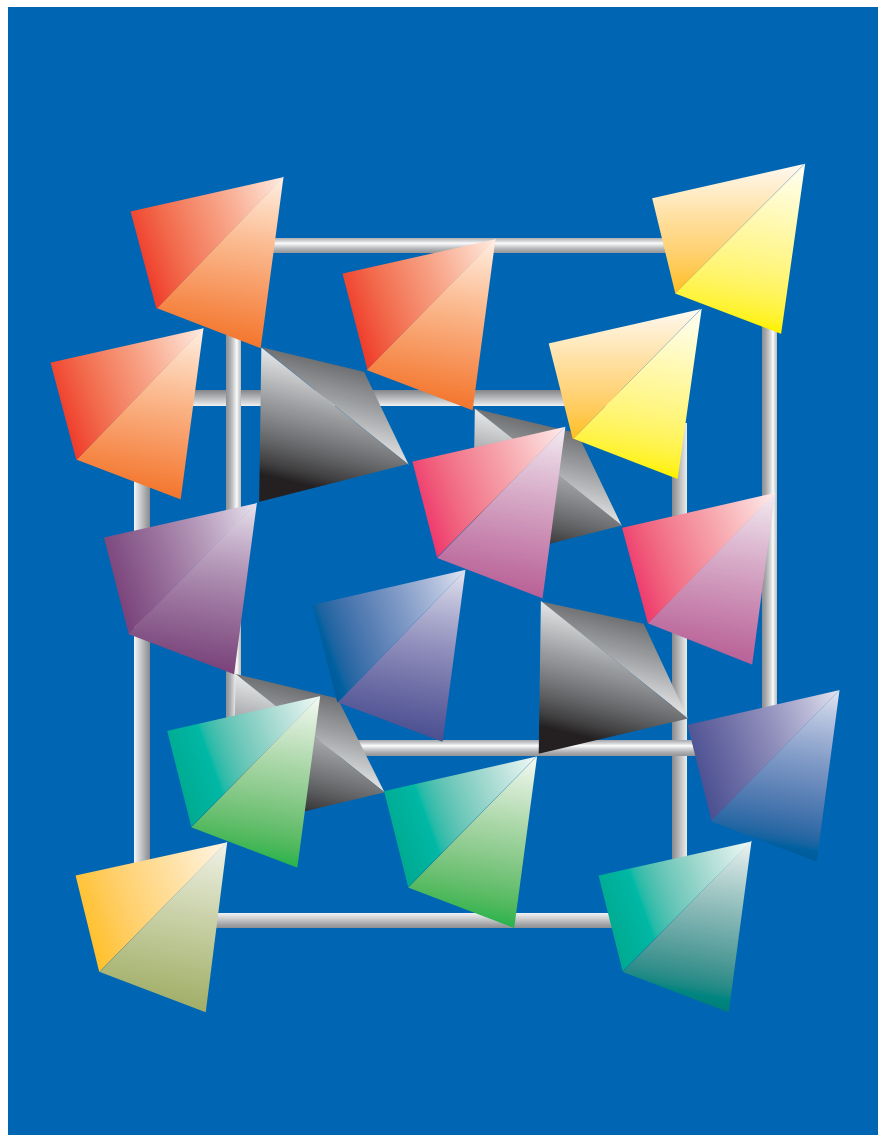




Durferrit Salts and Auxiliary Products



Product Catalogue

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Nitrocarburizing

The process of nitrocarburizing involves enriching the surface of ferrous materials with nitrogen and small amounts of carbon. This thermochemical treatment enhances wear resistance and fatigue strength. Used together with an intensely oxidative cooling bath, very attractive black, wear and corrosion resistant, surfaces will be produced.

Salts for nitrocarburizing

With TENIFER and ARCOR we offer two different environment-friendly processes for nitrocarburizing. Compared with TENIFER less porous compound layers can be produced with the ARCOR process. Which of both processes is the most appropriate one depends on the requirements and the geometry of the parts. Our Technical Sales Department will be pleased to giving you advice to make the right choice. (technical-service@durferrit.com)


TUFFTRIDE process

Product	Application	Working temperature in °C
 TF 1	Cyanide-free top up salt for TUFFTRIDE baths; for treating ferrous materials. For use only with REG 1 regenerator.	480 – 630
REG 1	Environment friendly non-toxic regenerator for TF 1 baths.	
AB 1	Oxidizing salt for cooling TF 1 treated components; greatly improves corrosion resistance. (TUFFTRIDE QPQ process).	370 - 420
AB 1 A	Starter salt for the initial filling of AB 1 baths.	



ARCOR – Process




Product	Application	Working temperature in °C
		
CR2	Non-toxic regenerator for CR4 baths.	
CR4	Cyanide-free top up salt for treating ferrous materials for the ARCOR C process. For use only with CR2 regenerator.	540 – 590
CR8	Cyanide-free top up salt for treating ferrous materials for the ARCOR V or N process. For use only with CR9 regenerator.	480 – 630
CR9	Non-toxic regenerator for CR8 baths.	
OXINIT RN	Oxidizing salt for cooling parts treated with CR4 or CR8; leads to an important increase of the corrosion resistance	420 – 440
OXINIT 1.2	Starter salt for the initial melting of OXINIT baths	

NSK

Product	Application
NSK	In special cases for the artificial activation of TF 1 baths.

Solid nitrocarburizers

Product	Application	Working temperature in °C
		
AKTIVATOR PULNIERPULVER	For nitrocarburizing by the box pack process; environment friendly.	450 - 600

Carburizing and Carbonitriding

During the processes of carburizing and carbonitriding, carbon (carburizing) and carbon plus nitrogen (carbonitriding) diffuse into the surface of the work piece. Apart from the steel grade, the amount of final carbon in the surface zone is determined primarily by the carburizing activity of the salt melt (activation level). The carburisation depth is a factor of the treatment temperature and time.

Salts for carburizing and carbonitriding

Product	Application	Working temperature in °C
durferrit		
CECONTROL	An environment friendly cyanide-free regenerator. For use only with the base salts CECONTROL 50 H, 80 B, N80 B, 110 B and N110 B.	
CECONTROL 50 H	Used in special cases as a shallow carburizing salt to achieve a surface carbon level of approx. 0.5% C. It is used as cyanide-free base salt and to top up the working bath in combination with CECONTROL regenerator only. Suitable for martempering.	780 – 950
CECONTROL 80 B CECONTROL N80 B	For surface carbon levels of approx. 0.8 and 1.1% C. It is used as cyanide-free base salt and as top up in combination with CECONTROL regenerator only.	820 – 950
CECONTROL 110 B CECONTROL N110 B	Suitable for martempering. CECONTROL N80 B and N110 B are bariumchloride-free.	
CECONSTANT 80 CECONSTANT 80 A CECONSTANT N80 CECONSTANT N80 A	Salts (one-salt system) to achieve a surface carbon level of approx. 0.8 and 1.1% C. CECONSTANT 80 A / 110 A are used as the base salts for melting new baths.	850 – 950
CECONSTANT 110 CECONSTANT 110 A CECONSTANT N110 CECONSTANT N110 A	CECONSTANT N80, N80 A, N110 and N110 A are bariumchloride-free.	
RAPIDEEP H	Salt (one-salt system) for a surface carbon level of approx. 1.0% C. Not suitable for martempering. A mixture of RAPIDEEP H and GS 540 is used as base salts for melting new baths.	760 – 950
A 4 / C 3 A 5 / C 3 C 5 / C 3	Two-salt systems used to achieve different surface carbon levels. Suitable for martempering, depending on bath operating temperature.	800 – 950
GS 540 / C 3		700 – 950



Salts for carbonitriding

Product	Application	Working temperature in °C
durferrit		
C 2 M	Carbonitriding depths up to 0.2 mm. Not suitable for martempering.	750 – 860
GS 540 / C 3	Carbonitriding depths up to 0.3 mm. Suitable for martempering, depending on bath operating temperature.	700 – 950



Solid carburizing products

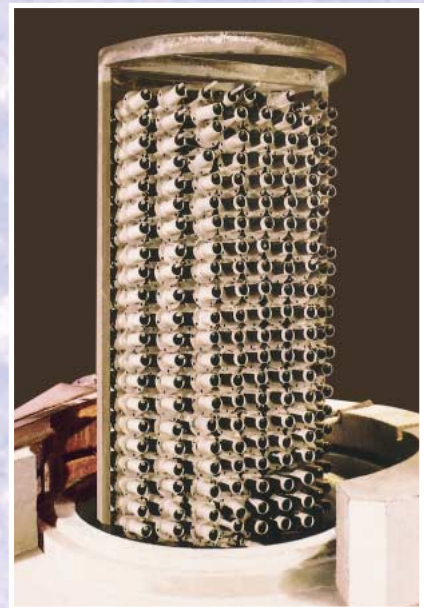
Product	Application	Working temperature in °C
durferrit		
KG 6	Mild carburizing granules for carburizing alloyed steels by the box pack process to depths over 0.6 mm.	900 approx.
KG 30	Strong carburizing granules for carburizing non-alloyed and alloyed steels by the box pack process with depths up to approx. 0.6 mm.	900 approx.
KRATOS L	Mild carburizing granules for carburizing alloyed steels with depths up to 0.6 mm. Available in various grain sizes.	900 approx.
KRATOS U	Intense carburizing granules (coarse) for case hardening. Use: similar to KG 30. Available in various grain sizes.	900 approx.
KRATOS SPEZIAL 0/5	Extremely fine-grained powder for carburizing very small bores etc.	900 approx.
LEKONA 27	A substitute for the charred leather previously used in precision engineering.	900 approx.
HÄRTEKOHLE SPEZIAL PW	Carburizing product for die sets.	900 approx.
AUFSTREUHÄRTE-PULVER	For surface hardening tools such as chisels. The powder is sprinkled onto the tool after bringing it to red heat with the welding torch or in a furnace. Also known as yellow potash, nitrogen powder etc.	

Annealing and Hardening

Annealing is a process of heat treatment that involves heating to a certain temperature followed by holding at temperature and controlled cooling. Hardening consists of austenitizing and cooling to form martensite.

Salts for non-inert annealing and hardening

Product	Application	Working temperature in °C
durferrit		
GS 230	Martempering bath for temperatures over 300°C. For steel tempering.	270 – 600
GS 430	Steel tempering and annealing. Quenching steels with hardening temperatures over 950°C that cannot be quenched in AS baths.	500 – 700
GS 520	Replenisher salt for GS 430 baths.	
GS 540	Heating and annealing. Depending on the temperature, annealing duration and state of the bath, decarburization will take place to a greater or lesser degree.	600 – 950
GS 560	For annealing silver, rolled gold and brass.	600 – 850
GS 660	Environment-friendly salt for the annealing of non-ferrous metals and steel. Depending on the temperature, annealing duration and state of the bath, decarburization will take place to a greater or lesser degree.	750 – 900
GS 670	Heating and annealing. Depending on the temperature, annealing duration and state of the bath, decarburization will take place to a greater or lesser degree.	750 – 1000
GS 750	Heating and annealing. Depending on the temperature, annealing duration and state of the bath, decarburization will take place to a greater or lesser degree.	850 – 1100
GS 960	Heating and annealing. Depending on the temperature, annealing duration and state of the bath, decarburization will take place to a greater or lesser degree. For saturating new linings.	1050 – 1250
PSA	For isothermal transformation in the perlite state. Used mainly for casehardening steels.	600 – 700
PSN	PSA: base salt for melting out new baths. PSN: top up salt.	



Additive salts; cyanide-free

Product	Application
durferrit	
R 2	Regenerator for the prevention of decarburization and oxidation in conjunction with GS 430, GS 540, GS 670 and GS 750.
R 3	Regenerator for the prevention of decarburization and oxidation in conjunction with GS 660.



Salts for inert annealing and hardening; cyanide-free

Product	Application	Working temperature in °C
durferrit		
GS 430 / R 2	Neutral salt for the heat treatment of steel and NF metals. For use with additive salt R 2. Not suitable for quenching in AS baths.	500 – 850
GS 540 / R 2	Neutral salt for the heat treatment of steel and NF metals. For use with additive salt R 2. Suitable for quenching in AS baths provided the austenitizing temperature is below 950°C.	600 – 900
GS 660 / R 3	Environment friendly neutral salt for the heat treatment of steel and NF metals. For use with additive salt R 3. Suitable for quenching in AS baths provided the austenitizing temperature is below 950°C.	750 – 900
GS 670 / R 2	Neutral salt for the heat treatment of steel and NF metals. For use with additive salt R 2.	750 – 1000
GS 750 / R 2	Suitable for quenching in GS 430 from austenitizing temperatures exceeding 950°C.	850 – 1100
GS 540 / Semper-neutral 950	Neutral salt for the annealing of steel which also protects against decarburization. For treating temperatures from 950°C. Cooling in a GS 430 martempering bath.	900 – 1150

Additive salts; with cyanide

Product	Application
durferit	
C 1	An additive for annealing salts GS 540, GS 560, GS 660 and GS 670 that prevents decarburization and oxidation. For use when the carbon content of C 3 is undesirable.
C 3	An additive for annealing salts GS 540, GS 560, GS 660 and GS 670 that prevents decarburization and oxidation. Contains active carbon to form a bath cover.


Salts for annealing and hardening; with cyanide

Product	Application	Working temperature in °C
durferit		
CECONTROL	An environment friendly cyanide-free regenerator. For use only with the base salts CECONTROL 50 H, 80 B and N80 B.	780 – 950
CECONTROL 50 H <i>cyanide content 2–4% KCN</i>	Used both as a cyanide-free base salt for melting new baths and as a top up salt to prevent carburization of annealing baths.	780 – 950
CECONTROL 80 B CECONTROL N80 B <i>cyanide content 2–4% KCN</i>	regenerator. Suitable for martempering. CECONTROL N80 B is bariumchloride-free.	800 – 950
GS 540 / C 3 <i>cyanide content 3–5% KCN</i>	Used in combination with C 3 to prevent decarburization. Suitable for martempering	700 – 950
GS 560 / C 3 <i>cyanide content 5–10% KCN</i>		580 – 950
GS 660 / C 3 <i>cyanide content 5–20% KCN</i>		700 – 950






Salts for the heat treatment of high-speed steels

Product	Application	Working temperature in °C
		
CARBONEUTRAL	For austenitizing of high-alloyed tool steels and HSS. Suitable for cooling in the GS 430 bath.	1000 –1300
SEMPERNEUTRAL 950	Salt for the heat treatment of high alloyed tool steels and HSS; protects against decarburization. Also used in conjunction with GS 540. Suitable for cooling in the GS 430 bath.	1100 –1300
SEMPERNEUTRAL 1100	For the heat treatment of HSS; protects against decarburization. Suitable for cooling in the GS 430 bath.	1200 –1300

Solid annealing products

Product	Application	Working temperature in °C
		
GLÜHKOHLE H	For scale-free annealing of ferrous materials. Refer to supplier for choice of annealing carbon.	900 –1000
GLÜHKOHLE G	Available in different grain sizes.	800 –1000
GLÜHKOHLE K		900 –1200

Quenching and Tempering

Quenching means cooling in oil or a salt melt to achieve an even temperature throughout the work piece, preferably before the formation of martensite. Tempering involves heating a component to a temperature below A_{c1} and holding it at that temperature, followed by cooling at a rate defined according to the application.

Salts for quenching and tempering

Product	Application	Working temperature in °C
durferrit		
AS 140	Austempering, martempering, tempering, and blueing. Not for use with work pieces which are heated up to above 950°C and salts which contain more than 13 % KCN.	160 – 550
AS 220	Austempering, tempering, and blueing.	250 – 550
AS 235	Austempering, tempering, and blueing. Nitrite-free in the as-received condition.	280 – 550
AS 300	For tempering, blueing and bright annealing of brass at temperatures between 550°C – 600°C.	340 – 550



Quenching Water Additives

For hardening non-alloyed and low alloyed steels such rapid cooling rates are required which can only be achieved by water or aqueous solutions for certain wall thicknesses. Water without additives has a high quenching rate, but the resulting gas bubbles adhere to the surface of the steel. This can be prevented by using additives.

Quenching water additives

Product	Application	Working temperature in °C
durferrit		
HYDRODUR	Quenching water additives for improved water quenching performance; concentration 10 - 12 %.	up to 70
HYDRODUR GF		
HYDRODUR 20		
HYDRODUR D		

Corrosion Protection

After cleaning, the work piece must be treated to prevent the very sensitive metal surface against corrosion.



Corrosion inhibitors

Product	Application
durferrit	
DRS 3	A dip emulsion that prevents post-rusting.

Covering Products

Covering products are used to minimize the heat dissipation from salt baths (energy saving), to reduce the cyanide loss from carburizing baths and to mitigate the exposure of operators to heat.

Covering products for salt baths

Product	Application
durferrit	
AKTIVAT	Covers baths containing cyanide, specifically for CECONTROL baths.
SCHUPPEN-GRAPHIT	Covers baths containing cyanide.
ABDECKKOHLE	Covers baths with and without cyanide. Not suitable for high temperature baths.
DUROPERL	Covers high temperature baths, specifically for CARBONEUTRAL and SEMPERNEUTRAL baths.

Thermochemical Cleaning of Metallic Surfaces

Cleaning salts

Cleaning salts are used for the quick and gentle removal of coatings which are difficult to dissolve, even in narrow crevices and small bore holes.

Product	Application	Working temperature in °C
KOLENE®		
ALKO® N	For descaling titanium.	200 – 220
No. 4	Removes moulding sand, graphite, oil coke, casting crust and scale. For cast iron, steel and cast aluminium.	400 – 500
No. 6	Removes paint, oil carbon and plastics from aluminium and steel work pieces, also grey cast iron.	300 – 400
No. 10	Removes organic materials: semi and fully synthetic plastics, paint, lacquer, grease, oil, resin, carbon, graphite, rubber etc. Ideal for cleaning chrome-alloyed tools.	380 – 480
No. 5	Removes organic materials: semi and fully synthetic plastics, paint, lacquer, grease, oil, resin, carbon, graphite, rubber etc. Some strongly reactive plastics. Ideal for cleaning steel and cast iron.	400 – 500
DGS	Removes scale and rolling skin; metal oxides, glass residue (drawing agent), sand residue, oil coke, oil, grease and other organic traces from stainless steels and other Cr/ Ni materials.	370 – 540
RS 700	Removes ceramic moulding material based on silicon and aluminium oxides, also zirconium oxide, from precision castings. Devitrifies Pt Rh spinning nozzles and similar components, removes enamel.	600 – 700



Cleaning additives

are used as aqueous solutions to clean off salt adhering to surfaces.

Product	Application
durferrit	
SILIRON HS	A water additive that enhances the cleaning action of salt-contaminated components; Concentraion 3 - 5%.

Heat Transfer and Vulcanizing

Very often chemical processes take place in a closely defined and frequently very narrow temperature range. In industrial plants, salts are used as heat transfer media for heating and cooling as well as for holding at constant temperature.



Salts for heat transfer and vulcanizing

Product	Application	Working temperature in °C
durferrit		
ASD	Heat transfer salt for the chemical industry.	180 – 450
ASD REG	For regenerating ASD salts.	
HT 400	Heat transfer salt for the chemical industry for use at high temperatures.	> 400
RUBBERCURE	For vulcanizing in LCM and PLCV plants.	> 180
RUBBERCURE REG	For regenerating RUBBERCURE salts.	
RUBBERCURE LAS	Nitrite-free vulcanizing salt	> 160

Aluminium Heat Treatment

Work pieces made from aluminium and aluminium alloys are usually solution treated and age-hardened during processing.

Brazing: Dip-brazing of aluminium and aluminium alloys with brazing preforms or paste and solder-coated sheets.

Salts for the annealing of aluminium and aluminium alloys

Product	Application	Working temperature in °C
durferrit		
AVS 220	For solution treatment age-hardened aluminium alloys containing a maximum of 10% magnesium	270 – 550
AVS 240		290 – 550
AVS 250		300 – 550
AVS 300		350 – 550
AVS 300 REG	For regenerating AVS 300 salts.	



Salts for aluminium brazing

Product	Application	Working temperature in °C
durferrit		
ALUBRAZE 560 E	For dip-brazing of aluminium and aluminium alloys.	580 – 650
ALUBRAZE 520		565 – 650
ALUBRAZE R	For regenerating ALUBRAZE 560 E and ALUBRAZE 520 melts.	

Blackening

Blackening is performed by immersing objects made from ferrous materials in a boiling alkaline oxidizing salt solution to produce a black layer of iron oxide on the surface.



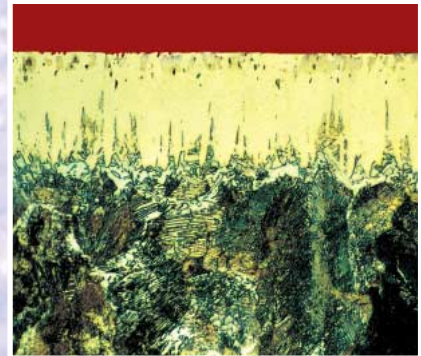
Salts for blackening / Pre-/post-treatment products

Product	Application	Working temperature in °C
durferrit		
FERROBLACK MH	Contains special active ingredients for a wide range of applications.	140 approx.
FERROBLACK OT		
FERROBLACK SPEZIAL / FERROBLACK PLUS	Ideal for blackening silicon steels and cast iron.	140 approx.
FERROBLACK HL	Particularly suitable for extra blackening of brazed joints.	140 approx.
FERROBLACK NIF	Nitrite-free salt for a bath very low in nitrites.	140 approx.
FERROSOL / FERROSOL HL	A booster salt for all blackening baths for easier colouring of cyanide hardened work pieces or work pieces with copper draw layers.	
STREICH-BRÜNIERBEIZE	A fluid product for brushing on or immersion at room temperature. Ideal for repairs and hobby use.	RT
BEIZENTFETTER	For descaling and partial degreasing prior to blackening.	RT
G 19	Alkaline hot degreasing prior to blackening.	60 – 80
G 22		
KALTOL	For dehydrating the washed work pieces at room temperature. Provides temporary corrosion protection.	
AUSKOCHÖL	For dehydrating the washed work pieces: This oil boils out the water-in-oil emulsion and neutralizes residual alkalis at the same time.	100 –110

Boriding

Boriding is the thermochemical enrichment of the surface of a work piece with boron. The resulting thickness of the boride film is determined by temperature, time and the composition of the material. Boriding can be done in powder or paste form. Boride layers have special benefits on components which have to withstand abrasive wear.

Boriermittel



Product	Application	Working temperature in °C
durferit		
DURBORID 1	A powder that creates perfectly formed boride layers for maximum performance. Shows hardly agglutination tendency. After treatment the work piece can be easy removed.	850 –1000
DURBORID 2	Fine granules for a good boride layer quality.	
DURBORID 3	Coarse granules that create boride layers.	
DURBORID SL	Powder, developed to create boride layers on special alloys.	850 –1000
DURBORID HM	Powder to create boride layers especially on carbides.	850 –1000
DURBORID PASTE	Water-based boriding paste, submersible and sprayable, hardly drips for high quality layers. Also suitable for partial boriding. Must be used with an inert gas (Ar, N ₂ or forming gas).	850 –1000
DURKRIT	Serves as a covering during paste boriding and for filling up areas in which boriding is not necessary.	

Hardening Masking Compounds

Hardening masking compounds are used primarily for the thermo-chemical treatment of metals, mainly steels, to prevent the diffusion of unwanted elements into the surface of the work piece.



Masking compounds

Product	Application
durferrit	
ATOMIN	An environment friendly plastic compound for masking work pieces during case hardening where a certain amount of contraction by the compound is beneficial, e.g. small bores.
REKORD / REKORD CU	An environment friendly plastic compound for masking areas of work pieces that must stay soft during case hardening. Also used to protect tool steels from overheating or rapid cooling.
ANTIDUR	An environment friendly immersible masking compound for case hardening.
CONTRADUR / CONTRADUR OX	A lacquer-based compound for carburizing in solid carburizing products; can be brushed on, sprayed on or submersed. Also suitable for partial boriding. Contains organic solvents.
CONTRADUR GAKO	A lacquer-based masking compound for gas carburizing; can be brushed on, sprayed on or submersed. Contains organic solvents.
BLACK 15	A lacquer-based masking compound for gas carburizing; can be brushed on, sprayed on or submersed. Contains organic solvents. Particularly good protection.
WAGA	An environment friendly masking compound for gas carburizing that can be brushed on or submersed. Mainly for deep case hardening.
WAGA Plus WAGA T	Environmental-friendly masking compound for gas carburizing especially at large case depths. Application by brushing (WAGA Plus) or submersing (WAGA T).
Contradur UDK	A solvent-based masking compound, specially developed for use in low pressure or vacuum carburizing, but also suitable in gas carburizing.
S100	Protection against diffusion during gas and powder nitriding. Contains organic solvents.
VERDÜNNER I	A thinner for use with CONTRADUR OX, CONTRADUR GAKO, and S 100.
VERDÜNNER II	A thinner for use with CONTRADUR, BLACK 15 and UDK.

Aqueous lacquer based masking compound

Product	Application
durferrit	
CONTRADUR WSC 200	Aqueous lacquer based masking compound for use in gas carburizing, brushable, can be diluted with water, easy to wash off.
CONTRADUR WSC 201	Aqueous lacquer based masking compound for use in gas carburizing, brushable, can be diluted with water, easy to wash off.
CONTRADUR WSN 100	Aqueous lacquer based masking compound for protection against gas nitriding, can be diluted with water, brushable and submersible, easy to wash off.
CONTRADUR WSP 300	Aqueous lacquer based masking compound for protection during case hardening in solid carburizing media, can be diluted with water, submersible and brushable, also usable as protection during boriding.



Product list

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AB 1 / AB 1 A _____	2	CECONTROL N110 B _____	4
ABDECKKOHLE _____	11	CECONSTANT 80 _____	4
AKTIVAT _____	11	CECONSTANT N80 _____	4
AKTIVATOR _____	3	CECONSTANT 80 A _____	4
ALUBRAZE 520 _____	14	CECONSTANT N80 A _____	4
ALUBRAZE 560 E _____	14	CECONSTANT 110 _____	4
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Product list

FERROBLACK SPEZIAL _____	15	RAPIDEEP H _____	4
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GS 560 _____	6; 8	RUBBERCURE _____	13
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Details we provide on our products and appliances as well as our plants and process methods are based on comprehensive research work and operational experience. We provide such data either verbally or in writing to the best of our knowledge and belief on the understanding that they do not present any warranty concerning the existence of specific characteristics in our products, but reserve the right to make technical modifications in the course of product development.

This does not, however, relieve the user of his responsibility to check our data and recommendations for his own application before using them. This also applies - particularly for shipment abroad - with regard to the maintenance of protection rights of third parties and to applications and process methods not expressly declared by ourselves in writing. In the event of loss our liability is limited to replace goods and services on the same scale as is stipulated for quality defects in our General Conditions of Sale and Delivery.



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