Kalenborn Offers
Optimized Wear Protection
for Plant Components
and Pipe Systems
Why Wear Protection?

Reduce Costs and Avoid Downtime

The transport of bulk materials in many basic industries and in coal fired power stations is associated with heavy wear of the system components. Not only is the original equipment investment lost, plant shutdowns and production losses combine to destroy the capital base of the company.

This is unacceptable in today’s competitive world markets. The solution to the problem is reliable wear protection. The selection of the appropriate material is of vital importance as well as its correct application.

Kalenborn have been dedicated to plant protection since originally developing fused cast basalt for wear reduction and cost savings. Starting with fused cast basalt more than eighty years ago, a wide range of wear resistant materials has been developed with each material offering special characteristics. The materials are valuable, but the knowledge from experience gathered all over the world in many branches of industry is just as important.

The highest cost in many situations is the lost production time due to unplanned outages. The money saved by using low cost steel components can result in a much higher cost later. Abrasion resistant pipes and plant components save money as repair frequency is greatly reduced and production time is increased. In some instances, a single avoided repair will pay for the added abrasion protection.

Efficient wear protection by ceramic and metallic materials
Design, Manufacture, Delivery and Installation of Tailor-Made Wear Resistant Linings

Design
Kalenborn’s engineers can design customized, cost saving solutions for new or existing equipment. All the details of the solution come from a single source: starting with advice on application, measurements on site, design services, manufacture of the lining through to proper installation.

Manufacturing
The foundation of the abrasion resistant systems offered by Kalenborn consists of different materials with individual characteristics:
- ABRESIST fused cast basalt
- KALCOR zirconium corundum
- KALOCER high alumina ceramics
- KALSICA silicon carbide ceramics
- KALCERAM hard ceramics
- KALMETALL metal wear protection
- KALCRET hard compound
- KALPOXY hard compound

Installation and Erection
Proper installation and erection require knowledge based on a wide range of experience. Installation of the engineered wear resistant linings can be performed or supervised by Kalenborn specialists in our workshops or on site all over the world.

Which Material for Which Task?
Wear protection has to be matched to each application. The better the material and the installation method have been adapted to the specific problem, the more durable and economical the solution.

Which material will be most suitable is determined after all the factors are known. There is no magic formula or calculation principle, but knowledge based on 90 years of practical experience of Kalenborn.
Kalenborn offers a complete array of wear protection materials to achieve acceptable service lifetimes.

In addition, Kalenborn has extensive experience in the field of slide promotion. Interruptions of material flow inside of bunkers and silos must be avoided and Kalenborn covers the entire material range with plastics as well as metallic and ceramic materials. Kalenborn can supply a tailor-made solution for almost any particular problem. Our experts are prepared to be of assistance.

Coal Fired Power Plants
Plant components are subject to substantial wear in coal storage and coal transport systems. This includes coal pulverizing and injection into the boiler, dust collection and ash removal including fly ash and bottom ash. The situation is similar for limestone and gypsum in desulphurization systems.

Iron and Steel Industry
Critical systems of the iron and steel industry are the raw material storage and processing at the sinter plant, coke plant and blast furnace operation. Comprehensive wear protection is also an absolute must for steel making and in the rolling mills.

Cement Industry
Endangered plant systems are raw material storage and processing. This includes pulverizing and feeding into the rotary kiln as well as handling of coal, clinker, additives and cement.

Further Industries
Kalenborn are active in a wide range of industries and these include:
- chemical industry
- coal mines
- foundries
- glass works
- loading and unloading plants
- mineral processing
- ore beneficiation
- ore mines
- recycling plants
- steel works
- waste incinerating plants
Worldwide Organization

The headquarters of the company are located in Germany at the original production site of fused cast basalt. From here the company organizes international sales and supplies the various products for most applications.

Affiliated or associated companies are responsible for regional markets.

In addition, Kalenborn has set up a close network of regional representatives and cooperating companies that ensure contact with our customers.

USA
Kalenborn Abresist, USA
Kalenborn Technologies, USA

CANADA
Kalenborn Canada

BRASIL
Kalenborn do Brasil

FRANCE
Kalenborn France

GERMANY
Kalenborn Kalprotect, Germany

POLAND
Kalenborn Delma, Poland
Kalenborn OSW, Poland
Kalenborn Bazalt, Poland

HUNGARY
Kalenborn Refmon, Hungary

SINGAPORE
Kalenborn Asia, Singapore

PHILIPPINES
Kalenborn Weartech Philippines

Around the world, we are readily available to attend to your needs. The Kalenborn Group offers its international customers a local, well-connected network of experts everywhere.
A wide range of different materials with different characteristics can be chosen to protect against wear. Pipe linings made of mineral, ceramic or metallic materials have proven to work well.

Clear Advantages:
- long lifetime
- maintenance free operation
- no operation interruption
- no production losses
- no contamination of the conveyed materials due to abrasion, mixture or oxidation
- physiologically harmless, suitable for food products
- smooth surface to achieve good flowability and to avoid plugs
- reduced pressure losses and lower energy cost

To achieve both technical and economical wear protection, many factors have to be taken into account. The choice needs to be based on the application. The best solution for long life and economical abrasion protection depends upon the proper selection of the lining material as well as knowledge of the expected cost.

Example of a Wear Protected Pipe Bend

- Steel casing
- Wear resistant lining – also in the area of turbulent flow
- Simple installation with flanged connections
- Mortar
- Good flow characteristics due to permanently smooth surface

Typical example of a ceramic lining:

1 Lining
2 Mortar
3 Steel
The entire length of a hydraulic pipeline needs to be protected against abrasion. Under typical conveying conditions and general operating procedures, ABRESIST has proven to be extremely effective. To reduce the severe abrasion of the bends in pneumatic systems, abrasion resistant piping components with internal linings – such as ABRESIST – should be used. Because of continuing turbulence in the straight sections after bends, abrasion resistant pipes should be installed. Recommended length: 10 times the inside diameter or 1 – 2 meters.

### Examples in Hydraulic Conveying

<table>
<thead>
<tr>
<th>Industry</th>
<th>Material</th>
</tr>
</thead>
<tbody>
<tr>
<td>blast furnace plants</td>
<td>slag</td>
</tr>
<tr>
<td>chemical industry</td>
<td>caustic solutions with solids</td>
</tr>
<tr>
<td>coal fired power stations</td>
<td>bottom ash</td>
</tr>
<tr>
<td>hard coal mining</td>
<td>raw coal</td>
</tr>
<tr>
<td>hard coal washeries</td>
<td>heavy media with solids</td>
</tr>
<tr>
<td>phosphate plants</td>
<td>phosphate ore</td>
</tr>
<tr>
<td>potassium &amp; salt industry</td>
<td>potassium salts, kieserite, salts</td>
</tr>
<tr>
<td>quartz &amp; gravel plants</td>
<td>gravel, sand</td>
</tr>
<tr>
<td>refuse incineration</td>
<td>non-combustible residue, slag</td>
</tr>
<tr>
<td>rolling mills, continuous casting plants</td>
<td>sintered material, mill scale</td>
</tr>
<tr>
<td>sewage treatment plants</td>
<td>sewage sludge</td>
</tr>
</tbody>
</table>

### Examples in Pneumatic Conveying

<table>
<thead>
<tr>
<th>Industry</th>
<th>Material</th>
</tr>
</thead>
<tbody>
<tr>
<td>aluminum plants</td>
<td>calcined alumina, bauxite, electrode carbon</td>
</tr>
<tr>
<td>abrasive plants</td>
<td>abrasives</td>
</tr>
<tr>
<td>blast furnace plants</td>
<td>sintered material, lime, lime-oxygen mixture, packing compound, pulverized coal</td>
</tr>
<tr>
<td>cement plants</td>
<td>clinker dust, cement, blast furnace slag, fly ash</td>
</tr>
<tr>
<td>chemical plants</td>
<td>caustic lime, lime dust, fertilizer</td>
</tr>
<tr>
<td>coal fired power stations</td>
<td>pulverized coal, quick coke, fly ash, ash, slag, pyrite</td>
</tr>
<tr>
<td>foundries</td>
<td>quartz sand, molding sand</td>
</tr>
<tr>
<td>glass works</td>
<td>feldspar, quartz, kaolin, nepheline, cullet</td>
</tr>
<tr>
<td>grinding mills and animal feed</td>
<td>cocoa beans, corn, sunflower seeds, cereals</td>
</tr>
<tr>
<td>ore mines</td>
<td>concentrate, tailings</td>
</tr>
<tr>
<td>breweries, malting plants</td>
<td>hops, malt, rice</td>
</tr>
<tr>
<td>mineral wool &amp; insulation products</td>
<td>production waste, saw waste, perlite, stone dust</td>
</tr>
<tr>
<td>refuse incineration, vacuum refuse collection</td>
<td>industrial and domestic refuse</td>
</tr>
<tr>
<td>steel plants</td>
<td>carbon and limestone injection</td>
</tr>
<tr>
<td>technical carbon plants</td>
<td>technical carbon, graphite for electrodes</td>
</tr>
</tbody>
</table>
Proper Protection for Long Lifetime and Troublefree Operation

Abrasive wear occurs, in particular, when hard and sharp edged bulk materials are moved. But the material to be conveyed cannot be altered to reduce the problem. Therefore, protective measures have to be implemented for the protection of the system components.

A wide range of materials with varying characteristics is available to protect against wear. Pipe linings made of mineral, ceramic and metallic materials have proven to work well.

Clear Advantages:
- long lifetime
- maintenance free operation
- no operation interruption
- no production losses
- no contamination of the conveyed materials due to abrasion, mixture or oxidation
- physiologically harmless, suitable for food products
- smooth surface to achieve good flowability and to avoid plugs
- reduced pressure losses and lower energy cost

Principle of Wear Protected System Components

Reduced pressure losses and low energy cost

Abrasion resistant lining in zones of turbulence

Steel casing

Good flow properties due to smooth surface that lasts

KALCOR lining of a hopper in the sinter dust collector of a steel mill
The large rocks handled in quarries and mines are not the only problems for conveying and processing systems. In modern process plants, characterized by high throughput rates and conveying velocities, even apparently harmless materials cause significant wear.

Here is a list of typical abrasion problem components:

- ash pipelines
- belt discharge chutes
- bunker spirals
- bunkers
- channels
- chutes
- circulating air separators
- continuous flow conveyors
- cyclones
- dissolving tanks
- drying sections
- dust collecting equipment
- dust collecting pipes
- fans
- flue gas ducts
- flumes
- gravel release tunnels
- hoppers of rotary dryers
- hydrocyclones
- launders
- mixer troughs
- pipe bends
- pipes
- pneumatic backfill lines
- prilling tower bottoms
- pulpers
- receivers
- screw conveyor troughs
- separators
- settling basins
- shaft spirals
- sifters
- silos
- sinter troughs
tailings lines
- tanks
- thickeners
- tubular chain conveyors
- turbo separators
- vibrating troughs
- washing drums
ABRESIST fused cast basalt has been used successfully for years as a universal material for abrasion protection. Depending on the application and geometry, it can be used with temperatures up to 350 °C / 662 °F. Installed as original equipment, ABRESIST is an excellent solution to wear problems before they start.

During the manufacture of ABRESIST, selected natural basalt is melted and cast into molds, then moved into an annealing furnace. Due to the casting process, precise cylinders from 40 to 525 mm internal diameter can be produced for pipes and bends. Special tile shapes are engineered for larger pipe diameters and other equipment.

ABRESIST has an extremely hard and smooth surface. The material is corrosion resistant to most acids and alkalis. This makes ABRESIST very effective for pipelines where abrasion and corrosion occur together.

The idea to melt stone is age-old. However, melting of basalt only started with lab tests at the end of the 19th century. The development was hardly successful beyond this stage due to crystallization problems and inadequate application tests.

However, by the early 1920’s our company successfully produced a basalt based abrasion resistant material. Today, under the trade name ABRESIST, fused cast basalt has become a proven product worldwide.

ABRESIST Linings

Wear Resistant Fused Cast Basalt for Friction Induced Abrasion

ABRESIST fused cast basalt is a mineral based wear protection material for plant components when the conveying material produces friction induced abrasion.

Installation: cylinders or shaped components. In special cases epoxies or synthetic mortars may be used due to strong mechanical stresses and/or vibration. Where higher temperatures are concerned, potassium silicate mortar may be used for installation. Mechanical fixing is feasible as well.

Application temperature: up to approximately 350 °C / 662 °F depending on application and geometry.

Advantages: highly abrasion resistant, smooth surface that lasts, no corrosion.
Worldwide ash removal pipes lined with ABRESIST reach lifetimes of more than 30 years. This US power plant operates more than 10,000 meters of 294 mm ID pipes.

Flumes and hoppers of any shape can be lined with abrasion resistant ABRESIST

Hydraulic ash conveying pipe being manufactured at the Abresist Kalenborn Corporation plant in Indiana, USA

Raw material hopper in a German blast furnace plant

Coke bunker in the iron and steel industry

Irrigation wear protected by ABRESIST
Quite often screw-type elevators are used for transport in waste water treatment plants. Continued proper functioning of the annular gap requires its being protected against wear. ABRESIST is successfully used for that purpose even at diameters of 3,000 mm and 15,000 mm length.

Waste paper bales are mixed for paper recycling in pulpers. Since the bales contain considerable impurities the pulper bottom is durably protected with ABRESIST.

Hoppers of any shape for material discharge are fitted with ABRESIST as wear protection.

Chain conveyor for wet ash removal in a power plant. Drains cast into the lining reduce the undesired carrying of water to the discharge zone thereby lowering the water consumption rate.
The bends and straight extension sections of the feed pipes to cement silos have been lined with ABRESIST pipe for hydraulic ore transport.

Combi-sorter made of high-grade steel used by the paper industry – protected from wear by fused cast basalt tiles.

Fused cast basalt has performed well on automobile test tracks all over the world. Here, skid tiles are laid in Switzerland.

ABRESIST skid tiles at the right showing their natural surface; skid tiles with polished surface at the left to ensure a minimum friction coefficient.

The bends and straight extension sections of the feed pipes to cement silos have been lined with ABRESIST.
With the growing knowledge of preventive wear protection the demand for durable materials with extended service life has increased.

KALCOR, a zirconium corundum was developed for extreme abrasion resistance and high temperatures up to 1,000 °C / 1,832 °F.

Alumina and zirconia are formed into tiles, shaped components and cylinders. This shape capability allows KALCOR to be manufactured into many different components demanded by various industries.

KALCOR lined pipes

High temperature wear protection in a dedusting cyclone of a blast furnace plant in Europe
Wear protection for high temperatures involves problems due to thermal stress between the outer steel component and the rigid lining. These problems can be solved by using KALCOR as wear protection material and the right mechanical fixing method: bolted connections or welded steel inserts. Example: drying drum in a chemical plant at 800 °C / 1,472 °F.

KALCOR protection easily applied in high wear areas: special cast shapes or cut components (diamond tipped tools only)

Even surfaces of complicated structure can be safely protected against wear by KALCOR

KALCOR bend with special deflectors to distribute the conveying stream of coal
Flue gas dust collector for dust removal from petroleum coke calciner in an oil refinery at temperatures up to 450 °C / 842 °F: 10 cyclones incl. immersion pipes, supply channels and raw-gas bends have been lined with abrasion resistant KALCOR (top illustrations – right and left).

Pipe branching in pneumatic conveying pipe lined with KALCOR

Pulverized coal distributor with reliable KALCOR lining to ensure trouble-free operation

Pulverized coal bends lined with KALCOR zirconium corundum and welded-on unlined transition sections
Wear protection materials are steadily improving. Important considerations include the best possible adaptation and the specific application conditions. KALCOR-S zirconium corundum material has been engineered for good abrasion resistance and high temperature resistance up to 1,250 °C / 2,282 °F.

KALCOR-S is produced by cold forming aluminum oxide and zirconium oxide raw materials into tiles, shaped elements and cylinders and then sintering. This allows the production of elements tailored to a variety of system component geometries.

Installation: tubular and/or shaped elements are laid in cement mortar or special setting materials. Mechanical fixing systems are feasible in other cases.

Application temperature: up to approximately 1,250 °C / 2,282 °F - depending on the specific service conditions and geometry.

Advantages: highly wear resistant, temperature resistant, good thermal shock resistance.

The structure of KALCOR-S is practically free of voids

No problem with KALCOR-S: thin wall cylinders

Asymmetric cross section of a pipe with KALCOR-S lining
KALOCER is a member of the oxide family of ceramics, with aluminum oxide as the main component. Extremely high abrasion resistance is achieved by careful selection of the particle size and distribution.

Most tiles or cylinders are formed by pressing a dry powder of the ceramic. Machining of ceramic prior to kiln firing or slip-casting allows the manufacture of components with geometrically difficult shapes.

KALOCER can be manufactured in very thin tiles. This is an advantage when existing plant components have to be lined and space or weight are of critical importance.

Mechanically fixed special tiles of KALOCER protect the cone against wear even in case of thermal shock stress.

KALOCER can be manufactured in very thin tiles. This is an advantage when existing plant components have to be lined and space or weight are of critical importance.
Agitators and mixers subject to extreme wear can be durably protected with KALOCER tiles shaped to the specific equipment design.

Lining of a cyclone handling diatomaceous earth lined with 6 mm thick KALOCER tiles; the epoxy setting is resistant up to 180 °C / 356 °F.

Kalenborn offers KALOCER mosaics in different sizes: square, hexagonal or special design from 1.5 mm to 12 mm thickness. Mosaics can be supplied with book ends. Vulcanized solutions are available.

Skip collection chute with KALOCER lining installed at a European blast furnace plant; the shaped elements are up to 50 mm thick and some have been cut three-dimensionally.

Agitators and mixers subject to extreme wear can be durably protected with KALOCER tiles shaped to the specific equipment design.
KALOCER Linings

Chute for blast furnace lining in a European plant; the KALOCER lining is 50 mm thick

Octagonal hopper in a steel plant; the 50 mm thick KALOCER tiles have been three-dimensionally shaped and cut

Highly abrasion resistant KALOCER pipes to transport ore sludge in a mine in the Far East

Screw lined with high alumina ceramics operated in a potash plant

KALOCER lining of a mill for superfine grinding of coloured pigments

KALOCER pipe bricks are an economic alternative for lining pipes and bends
KALOCER mosaics of 1.5 to 12 mm allow flexible use; they are fixed by KALFIX epoxy setting compound.

Precisely cut and fitted KALOCER lining in a separator system assures trouble-free operation.

Lining a cyclone inlet with KALOCER; the arch shape enables fixing radial shaped elements in KALFIX setting compound whereas the headwall requires mechanical fixing by means of weld sleeves and ceramic caps.

KALOCER mosaics of 1.5 to 12 mm allow flexible use; they are fixed by KALFIX epoxy setting compound.
Silicon Carbide Ceramics with Extremely High Temperature Abrasion Resistance

Outstanding resistance against wear and thermal shock is achieved with KALSICA. KALSICA is part of the silicon carbide ceramics group and available in different qualities:

- Silicon infiltrated silicon carbide (KALSICA-S)
- Nitride bonded silicon carbide (KALSICA-N and -P)

High precision can be achieved in manufacturing KALSICA shapes, formed by pressing or casting, then sintering in a reactor kiln.

Wall thickness from 2 mm for the shaped components is another advantage of using KALSICA wear protection linings.

KALSICA
Silicon carbide ceramics for plant components for extreme wear, high temperature and/or thermal shock.
Installation: individual shapes and components laid in mortar on synthetic resin or mineral base or in temperature and acid resistant based mastics. Mechanical fixing is also possible.
Application temperature: up to 1.000 °C / 1.832 °F depending on application and geometry.
Advantages: highly abrasion resistant, resistant to thermal shocks and manufactured to close tolerances.

KALSICA hydro-cyclone for magnesite processing without steel jacket

For extreme wear in pneumatic transport

KALSICA lined pipe transition
1,200 mm diameter KALSICA-N cyclones guarantee reliable operation: the system separates silicon sand at temperatures up to 300 °C / 572 °F

Pulverized coal distributor made of KALSICA-N installed in a power station

Guide vanes of a separator made of KALSICA-A operated within a coal pulverizer

Burner cone for a power station made of KALSICA-N

KALSICA-N lining for a cyclone handling silane dust; major cone diameter 1,200 mm; wall thickness 30 mm
KALCRET hard compound is the general term for cement-bonded wear protecting materials. These are made from inorganic materials of high hardness and good wear resistance. The high density is attained by a well balanced particle size distribution of the individual components. The pores between the cement particles are filled with superfine particles of micro and nano silica.

Prefabricated Shaped Elements
KALCRET hard compound has performed well in practice as prefabricated shaped elements. Tiles and shaped elements are prefabricated at the Kalenborn plant and equipped with common attachment hardware, such as steel corner inserts.

Prefabricated Pipes and Bends
Pipes and pipe bends lined with KALCRET can be produced with an inside diameter of more than 40 mm. Inside diameters up to 600 mm are lined with castable KALCRET whereas the use of trowelled-on KALCRET is more economical for inside diameters beyond 600 mm.
Sinter dust transport pipe in a German cement plant

Scrubber inlet in a steel plant lined with sprayed-on KALCRET-BTS hard compound

Separator of a cement mill lined with KALCRET-BNX, up to 3,200 mm diameter

Prefabricated KALCRET bends for pulverized coal in a power station

Reliable protection of the dust collecting pipe of a clinker cooler with KALCRET-BNY fitted as prefabricated shaped elements with integrated insulation

Sinter dust transport pipe in a German cement plant
KALCRET-S can be sprayed on large surfaces quickly at rates of more than 5 m²/hour. Spraying can be done horizontally and vertically. It can even be worked overhead and enables the lining of complicated surfaces without difficulty.

Investigations have shown that the properties of sprayed-on linings do not differ practically from those of comparable vibration compacted linings.

The addition of steel or other fibers has positive effects on strength and structural stability. The types of fibers are chosen with due regard to the specific thermal, chemical and corrosive stress. The fibers are added to the mixture during the spraying process.

Advantages of KALCRET-S:
- time-tested wear protection compound
- excellent abrasion values as defined in ASTM
- homogeneous structure with little porosity
- smooth surfaces obtained by reworking
- minimum setting time
- short installation time due to high application rate beyond 5 m²/hour
- overhead working
- homogeneous, jointless and intensely compacted sprayed-on layer
- variable thickness options, preferably from 20 to 100 mm
KALCERAM hard ceramics is particularly suitable where moderate abrasion is encountered and the extreme wear resistance of high quality linings cannot be economically justified.

For this reason KALCERAM is used in some system components in coal fired power stations, refuse incineration plants, coking plants, processing plants, potash mines, steel works, chemical plants, quarries, ceramic factories, glass works, cement works, lime plants, etc.

Particular emphasis is placed on the abrasion resistance of the product. That is why KALCERAM is so different from other commercially available ceramic products.

Installation: made-to-measure tiles are laid either in cement mortar or KALFIX synthetic mortar.

Application temperature: up to approximately 350 °C / 662 °F (KALCERAM), up to approx. 1.000 °C / 1.832 °F (KALCERAM-K).

Advantages: average abrasion resistance, smooth surface, KALCERAM-K also shows good temperature resistance.

KALCERAM hard ceramics for plant components subject to moderate wear, e.g. coal bunkers and chutes, fine coal troughs, thickeners and chain conveyors.

High temperature KALCERAM-K chute in a coking plant provides good sliding properties even at high temperatures

Chutes lined with KALCERAM are a solution that lasts, e.g. for bag loading systems in cement plants

Even conical surfaces can be lined as required with cut KALCERAM tiles
Metal Wear Protection with High Hardness and Impact Strength

Kalenborn offer the complete array of metallic wear protection highlighted by long lifetime, flexible application, good impact resistance, relatively low weight and economic price/performance ratio.

The Kalenborn program:
- KALMETALL-C hard casting
- KALMETALL-HB hard steel
- KALMETALL-HM hard metal
- KALMETALL-S hard metal spraying
- KALMETALL-W hard overlay welding

Mixer blade with KALMETALL-HM and KALOCER combined lining

KALMETALL-HM used to protect a vertical roller mill

KALMETALL Linings

Hard castings of varying alloys and properties matched to the specific abrasion and impact wear requirements.

Installation: made-to-measure shaped elements in setting compounds; mechanical fixing and self-supporting structures are also possible.

Application temperature: up to approximately 350 °C / 662 °F depending on application and geometry.

Advantages: high wear resistance with satisfactory impact strength or high impact strength with satisfactory wear resistance, economic in case of series production.
Rotors for turbines made of KALMETALL-C 155

Asphalt mixers are subject to significant wear; they are effectively protected by KALMETALL-C

Shaft flight of KALMETALL-C proven in use for hard coal mining

Rotors for turbines made of KALMETALL-C 155

Typical applications of KALMETALL-C hard casting are pipe systems; here a pulverized coal pipe of a power station in South East Asia

Pulverized coal pipe armored with hard casting KALMETALL-C

Cyclone used in a soil decontamination system – effectively protected with KALMETALL-C

Various Alloys of KALMETALL-C Hard Casting
KALMETALL-W Linings

Hard Overlay Welding Services, Standard Plates and Complete Plant Components

KALMETALL-W incorporates several hard overlay welded steel systems that consist of a tough basic body and hard overlay welding.

The base metal provides the strength of the system. Depending on the specific application, it is made of standard or special steels.

The hard overlay welding is the wear layer. It consists of a C-Cr-Fe system with primarily chromium carbides. The carbides provide the extreme hardness of the overlay welding. Depending on the composition of the alloy, the hardness may be up to 820 HV.

Welding Service
Kalborn offers individual overlay welding for a variety of elements and components. KALMETALL-W allows Kalborn to be a specialist in the regeneration of grinding systems.

Hard Overlay Welded Plates
Standard plates are offered at varying qualities, thicknesses and dimensions. Special components can be custom fabricated any time. Components of self-supporting structures are characterized by low weight and high economy.

KALMETALL-W

Hard overlay welded steel systems that consist of a tough basic body and the hard overlay welding.

Installation: by overlay welding or use of standard plates to fabricate complete structures.

Application temperature: up to approximately 750 °C / 1,382 °F depending on application and geometry.

Advantages: high wear resistance and high impact strength combined with optimal adaptation to the customer’s requirements.

Kalenborn welding service, regeneration of a grinding table

Hard overlay welded standard plates
Pulverized coal burner lined with KALMETALL-W 145

Pressure equalizing pipe set up near a blast furnace; the base metal has a thickness of 30 mm, the thickness of KALMETALL-W 100 hard overlay welding measures 6 mm; 450 mm diameter

Separating cones of cement classifiers made of KALMETALL-W 100 as self-supporting structures

Pulverized coal burner lined with KALMETALL-W 145

Sieves for hot sinter made of KALMETALL-W 145

Pipe armored with KALMETALL-W 100 installed in a dust collecting system; inside diameter 400 mm, system thickness 8 + 5 mm

Screw conveyor protected with KALMETALL-W 100, diameter up to 2,000 mm, up to 10,000 mm length
Combined Linings

More Economical due to Similar Lifetimes
For all Plant Components

High conveying speeds and abrasive materials cause wear in material handling systems. However, the wear is of varying intensity in different areas. This is where a combination of the different wear resistant linings proves successful. Designed on the basis of prior successful experience, components can achieve similar lifetimes without some failing prematurely or other excessively protected.

KALOCER bottom of a concrete mixer for extreme stress, KALMETALL-W in the area of the discharge gate

Pipe bend with ABRESIST and KALOCER combined lining

Reliable Lining of pipe unions and transition sections by a combination of ABRESIST or KALCRET with KALCOR or KALOCER

In case of specific applications combinations of Kalenborn wear protection materials may be suitable, e.g. ABRESIST, KALCOR, KALOCER, KALCRET or KALMETALL
Abrasive sinter particles impinge on the KALCOR lining at 250 °C / 482 °F and at high velocity – combined with ABRESIST results in an economical solution.

Discharge device for abrasive sludge from a mixer tank as a combination of KALCOR, KALOCER and high-grade steel.

ABRESIST lining combined with KALCOR deflectors and an inspection device.

An appropriate combination of lining materials ensures an overall economical solution.

Combination of KALCOR and ABRESIST in a pulverized coal pipe in Europe.
Combined Linings

Use in a shredder system for plastic waste:
KALMETALL-C and KALCRET

Immersion pipe of a cyclone for separating granulated blast furnace slag in the cement industry; KALCRET and KALMETALL-W

Separator inlet housing designed as self-supporting structure made of KALMETALL-W and KALOCER subject to extreme stress

Pulverized coal distributor boxes protected with KALCOR for large surface lining and KALOCER to offer maximum wear resistance

Drum mixer for concrete lined with KALOCER high alumina ceramics; mixer tools made of KALMETALL-C hard casting and/or KALEN-PU plastics
Effective protection of a cyclone processing silica sand: KALCOR zirconium corundum and KALSICA silicon carbide ceramics

Octagonal hopper subjected to impact stress lined with three-dimensionally cut KALOCER shaped elements as well as KALMETALL-C shapes, each 50 mm thick

Kalenborn deviation pot with ABRESIST and KALOCER – the badly worn parts can be replaced

Coke wharf protected with KALCERAM-K on the sliding surface, with KALSICA-N in the zone of high wear and with KALMETALL-C in the area of impact stress

Impact protection in an extrados: KALMETALL-HM combined with KALOCER laid out as pipe brick
Installation and Erection
A precondition for effective wear protection is proper installation.

Appropriate installation and erection of the lining depend on material conveyed, application, equipment, design and installation position. It also depends on whether sliding or impact wear prevail, temperature or thermal shock stress, corrosive or acid exposure is present.

ABRESIST, KALCOR, KALOCER and KALSICA normally are laid in cement mortar or special setting compounds.

Higher temperatures require additional measures like mechanical fixing, f.e. especially if the subsurface has different thermal expansion than the wear protection lining.

Special fixing systems have to be used for KALMETALL. Details are available in the relevant brochures.

Kalenborn offer a complete program of proven KALFIX setting compounds.
Mechanical Fixings and High Temperature Applications

Tile with Hole
These are usually fastened to vertical and overhanging steel surfaces by means of countersunk bolts, conical weld sleeves or weld studs.

High Temperature Applications up to 1.000 °C / 1.832 °F
KALCOR, KALOCER and KALSICA are wear protective materials capable of withstanding high temperatures. A wide range of mechanical fixing methods and design details permit finding cost effective wear protection for any application. Moreover, KALCRET hard compound can be installed by casting, trowelling or spraying.

Tile with Steel Corner Inserts and Weld Straps
This mechanical fastening method enables installing the lining to steel surfaces by welding.

Tile with Groove
This method has proved useful as well and allows the fastening of linings to steel surfaces by welding.
Flanges and other Joints

Flange Joints
The connection of wear resistant pipes to each other or to regular steel pipes can be done with fixed and/or loose flanges.

Lined pipes can be connected to each other easily with a fixed collar and a loose turnable flange on one end.

A weld-on counter flange with larger bolt circle diameter on the unlined pipe is a proven solution to connect pipes.

Unlined pipes, pumps or fittings can be connected with a lined pipe using an adapter flange.

Gaskets
The recommended dimensions of pipe gaskets are as follows:

outside diameter = outside diameter of the collar
inside diameter = outside diameter of the steel pipe

Minimum gasket thickness: 2 mm.
The material depends on the specific conditions. All known gasket materials can be used.
Other sealing systems are possible.

Expansion Joint Sections
For longer pipelines wear resistant lined expansion joints of various designs are available to compensate for changes in length.

Expansion joints in a hydraulic bottom ash pipeline
Couplings
Wear protected pipes can be connected by any known coupling system.

Threaded Joint
When a pipeline is stressed by tension, e.g. when vertically suspended, threaded joints can be used.

Welded Connections
When flanged connections and couplings are not the answer, it is possible to connect wear resistant pipes by a welded connection.

Joint Couplings
Special joint couplings to compensate for difference in level and length.
## Wear Protection Systems

### Flexible Bends, Ceramics-Rubber Bonding and more ...

**KALFLEX Bends**

KALFLEX is flexible piping that can be easily installed with standard flanges. The core elements of the system are abrasion resistant segments that fit into each other. The segments are capable of moving in relation to each other, providing the desired flexibility.

The segments are enclosed in a rubber jacket containing a fabric insert, producing the needed stability and tightness.

**Abrasion Resistant KALMETALL-C Hard Casting**

The wear resistant segments are made of KALMETALL-C hard casting, resistant against both impact and sliding wear. The segments have diameters between 19 and 200 mm.

**KALOCER in Case of Maximum Wear**

The segments can be made of high alumina ceramics if they have to withstand very harsh conditions concerning sliding wear. The inside diameter ranges from 50 to 125 mm. For design reasons collars and flanges are made of hard casting and/or steel.

### Advantages:

- inside diameter ranging from 19 to 200 mm
- maximum temperature 110 °C / 230 °F
- pressure up to 10 bar
- preventive stockkeeping
- useful for diverter valves
- used as vibration reducing element
- used as expansion joint
- well suited in case of narrow space
- compensation of load cells

KALFLEX used as flexible pipe bend

KALFLEX as part of a diverter valve in the USA
KERAFLEX is ceramic or overlay welded tile vulcanized into rubber mats. The ceramic tiles can be of varying thickness up to 50 mm.

Advantages:
- impact resistant ceramic elements
- very hard and wear resistant surface
- impact resistant thanks to the rubber layer matched to the specific application and the optimal vulcanization

The KERAFLEX system

KERFALEX lining of a bin set up in a bulk material handling plant

KERAFLEX Ceramics Rubber Bonding

Kalenborn Deviation Pots

In pneumatic conveying systems an abrupt deviation of the material flow or discontinuous conveying frequently increases wear resulting in operational failures and costly repairs or replacements.

Kalenborn’s deviation pot with a wear resistant lining displays a completely different behavior. It withstands the extra stress and permits relining whenever needed.

Lining materials normally used include ABRESIST fused cast basalt and highly wear resistant KALOCER high alumina ceramics.

Advantages:
- standard sizes
- special solutions feasible any time
- wear protection materials selected based on the specific stress

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Electrical Wear Detection

The wear resistant lining is fitted on the OD with a low voltage electrical circuit. If the wear resistant lining wears through due to abrasion in the pipeline, the electrical circuit will be interrupted. This will sound an alarm and – combined with a suitable evaluation system – will indicate the pipe section concerned or the plant can be automatically shut down.

The electrical wear detection is available for all of the wear resistant materials of Kalenborn.

Pneumatic Wear Detection

The steel casing is twin-walled. Changes in the pressure level in the space between the two parts caused by a leak will activate an indicator or alarm or the plant can be shut down – similar to the electrical wear detection.

This system can be used for single pipes, complete pipelines or any mechanical plant.

Mechanical Wear Detection

The support structure and wear resistant lining are fitted with a bore hole. The length of the indicator pin monitors the thickness or condition of the protective lining when removed and inspected.

Additionally, a serrated wear measuring tape can be placed in a continuous groove of the abrasion resistant lining. The width of the visible saw tooth is an indication of the condition of the protective lining.
Pipes & Bends

Kalborn Company Standard Rd 6a
(Extract, Issue 05/2010)

**Designation of pipe bend:** Inside diameter (d) 60 mm, radius (r) 1,000 mm, angle (a) 90° as defined in Kalborn company standard Rd 6a:
* pipe bend Rd 6a id 60; r 1,000; 90°

**Dimensional tolerances:**
The dimensional tolerances specified in the Kalborn company standard Rd 6a are in accordance with DIN EN 1092-1, DIN 1626, DIN ISO 13920 degree of accuracy A (but length tolerance up to 1,000 mm ± 2mm, up to 2,000 mm ± 3 mm, greater length ± 4 mm).

**Materials for pipes and flanges:**
Unalloyed structural steel S235 JR; other material specifications feasible on request.

**Corrosion protection (external surfaces):**
* surface preparation: DIN EN ISO 12944-4 / DIN EN ISO 8501-1 – St 2 (manually cleaned)
* coating system: zinc phosphate primer, red brown (similar to RAL 3011) – NDFT 40 µm; suitable as transport protection.

Other surface preparation methods or coating systems are feasible.

**Flanges:** Straight pipes with fixed flanges, pipe bends with fixed collars and turnable flanges. Other designs and other fixing systems on request.

Recommended gasket geometry:
* outside Ø = outside Ø of the collar (d4)
* inside Ø = outside Ø of the steel pipe (d)
* thickness ≥ 2 mm

**Other standards:** Kalborn offer solutions for piping operating at higher pressures, higher temperatures and other specifications (incl. Pressure Equipment Directive PED 97/23/EG, AD2000 etc.).

<table>
<thead>
<tr>
<th>Pipes and bends</th>
<th>Flanges</th>
<th>Rings</th>
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<tbody>
<tr>
<td><strong>Lining inside diameter mm</strong></td>
<td><strong>Steel casing outside diameter * mm</strong></td>
<td><strong>Flange outside diameter mm</strong></td>
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*First figure for pipes, second figure for bends

Technical changes and errors are reserved
ABRESIST is a basalt based wear protection for plant components in which the material to be conveyed predominantly causes friction induced abrasion in bunkers, troughs, chutes, chain conveyors, mixers, separators, pipes, pipe bends, cyclones, etc.

**Installation:** the shaped cast tiles are laid in cement mortar. To meet special requirements other setting materials may be used, such as KALFIX synthetic mortar or potassium silicate based mortar for higher temperatures.

**Application temperature:** up to approximately 350 °C / 662 °F.

**Advantages:** high abrasion resistance, lasting smooth surface, no corrosion.

KALCOR is a material composed of alumina and zirconia. It is recommended for particularly high abrasion and/or thermal stress, e.g. in cyclones and separators, in chutes for hot sinter or cinder, for mixers, pipelines, etc.

**Installation:** the shaped cast tiles are laid either in cement mortar or special setting materials. Mechanical fixing is possible as well.

**Application temperature:** up to approximately 1,000 °C / 1,832 °F.

**Advantages:** high abrasion resistance, high temperature stability, resistant to impact and corrosion.

KALOCER High Alumina Ceramics

Special high alumina ceramics for system components exposed to extreme wear and/or thermal stresses for which thin linings or smooth surfaces are required, such as in circulating air separators, cyclones, screw centrifuges, vibrating chutes, fans, fan blades, etc.

**Installation:** shaped elements or thin tiles laid in epoxy mortar. KALOCER tiles are also vulcanized into rubber mats to be fastened by adhesive. Mechanical fixing is possible as well.

**Application temperature:** up to approximately 1,000 °C / 1,832 °F.

**Advantages:** high abrasion resistance, high temperature stability, resistant to impact and corrosion. Available in thicknesses from 1.5 mm.

KALMETALL Metallic Wear Protection

Metallic wear protection is offered in various qualities. It is particularly suitable as protection against sliding and impact wear. The range includes hard castings as well as overlay weldings.

**Installation:** Made-to-measure castings laid in setting compounds or mechanically fixed. Plates with overlay welding are fixed mechanically or designed as self-supporting structure.

**Application temperature:** up to approx. 350 °C / 662 °F (hard castings), up to 750 °C / 1,382 °F (hard overlay weldings).

**Advantages:** highly wear resistant and resistant against impact wear, castings economic upon series production, overlay weldings characterized by good adaptability.

KALCRET Hard Compound

Cement bonded hard compound for continuous lining of plant components where high wear and temperature occur, e.g. troughs, chutes, bunkers, cyclones, etc.

**Installation:** by trowelling, casting or spraying.

**Application temperature:** up to approximately 1,200 °C / 2,192 °F.

**Advantages:** high wear resistance and compressive strength, jointless lining and highly temperature resistant.

**Materials at a Glance**

**ABRESIST Fused Cast Basalt**

**KALCOR Zirconium Corundum**

**KALOCER High Alumina Ceramics**

**KALMETALL Metallic Wear Protection**

**KALCRET Hard Compound**

Ask Kalenborn Abresist for further information

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Kalenborn Wear Protection Solutions

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