

COR™FORGE F58 FC

DESCRIPTION

COR™FORGE F58 FC is a flux-cored, H-12 hot work alloy designed to provide wear resistant deposits.

APPLICATIONS

F58 is typically used to repair and rebuild H-12 and #2 tools and dies: forging, coining, and header dies, punches, extrusion mandrels, and tong bits. F58 also displays excellent cold work properties required for: forming and blanking dies, sledge hammer faces, and cutting edges for hatchets and punches.

PROCEDURE

A minimum preheat/interpass temperature of 850°F is recommended for hot work dies. Peen between passes while removing slag for optimum performance. Post heat at 850°F for 3 hours after welding, and then allow the deposit to cool below 200°F. Temper to desired hardness according to the temper chart for 1 hour/inch thickness. For a full heat treatment, refer to the AISI H-12 procedure.

WELDING PARAMETERS

Type	Size	Volts	Amps	Shielding Gas/Flux
MC-G	.045"	18-20	150-200	75%Ar-25%CO ₂
FC-G	1/16"	23-25	230-270	75%Ar-25%CO ₂
FC-G	3/32"	29-31	450-550	75%Ar-25%CO ₂

Submerged arc wires are available in 1/16"-3/16"; Use a neutral flux.

MECHANICAL PROPERTIES

50-55 Rc as welded

CLASSIFICATION

AISI H-12