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COR™FORGE F112 FC

DESCRIPTION

COR™FORGE F112 FC is a flux-cored, nickel-chrome-moly alloy designed for high temperature applications requiring strength and oxidation resistance. F112 FC offers a smooth, globular transfer and excellent controllability in the flat position.

APPLICATIONS

F112 FC is primarily used for overlaying press forging dies. It maintains strength at service temperatures up to 1500°F over extended contact periods.

PROCEDURE

Preheat and postheat according to the base material.

WELDING PARAMETERS

Type	Size	Volts	Amps	Shielding Gas/Flux
FC-G	.045"	25-27	150-190	75%Ar-25CO ₂
FC-G	1/16"	23-26	175-225	75%Ar-25CO ₂
FC-G	3/32"	25-27	275-350	75%Ar-25CO ₂

MECHANICAL PROPERTIES

Tensile Strength: 100,000 psi
Elongation: 30%

CLASSIFICATION

Chrome-Moly-Columbium Nickel Base Alloy