COR™ FACE 10V FC

DESCRIPTION
COR™ FACE 10V FC is a flux-cored, hardfacing wire fortified with carbon and vanadium to provide exceptional wear resistance and strength in cold work applications. It can also be polished to a high luster. This vanadium carbide alloy has excellent wear resistance for fine particle abrasion.

APPLICATIONS
Typical uses include punches and dies for blanking, piercing, and forming; slitting and trimming knives; hardfacing the cutting edge of earth moving equipment and cold extrusion dies.

PROCEDURE
Preheat according to base material.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Type</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
<th>Gas/Flux</th>
</tr>
</thead>
<tbody>
<tr>
<td>FC-G</td>
<td>.045</td>
<td>FC-G</td>
<td>18-25</td>
<td>150-250</td>
<td>1/2” 75Ar-25CO₂</td>
</tr>
<tr>
<td>FC-S</td>
<td>3/32”</td>
<td>FC-S</td>
<td>28-32</td>
<td>250-350</td>
<td>3/4” Lincoln 880</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES
Hardness of undiluted weld metal: 60 Rc