

COR™FACE 6201 FC

DESCRIPTION

COR™FACE 6201 FC is a flux-cored, M series high speed tool steel. This alloy maintains hardness, and resists abrasion at temperatures up to 1100°F.

APPLICATIONS

COR™FACE 6201 FC is mainly used to repair and reclaim AISI M-1 and M-2 high speed tool steels. It is also used to build composite parts, or give an M-1 wear surface on a less expensive base material. Typical applications include repairing broaches and drills, cutting edges on piercing, blanking, and trimming dies, and hardfacing earth moving equipment.

PROCEDURE

Maintain a preheat/interpass temperature of 700°F. Peen each bead while still forgeable. Cool to room temperature. Temper at 1000°F for 1 hour/inch thickness. Use an AISI M-1 procedure for a full heat treatment. No heat treatment is required for hardfacing applications.

WELDING PARAMETERS

Size	Volts	Amps	Stickout
FC-O .045"	23-28	160-200	1"
FC-O 1/16"	23-28	240-280	1.25"
FC-O 7/64"	25-29	425-475	1.5"

Also available in submerged arc.

MECHANICAL PROPERTIES

Hardness: 59-63 Rc as welded

CLASSIFICATION

M-1 type tool steel