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

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
</tr>
</thead>
<tbody>
<tr>
<td>FC-O .045”</td>
<td>23-28</td>
<td>160-200</td>
<td>1”</td>
</tr>
<tr>
<td>FC-O 1/16”</td>
<td>23-28</td>
<td>240-280</td>
<td>1.25”</td>
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<tr>
<td>FC-O 7/64”</td>
<td>25-29</td>
<td>425-475</td>
<td>1.5”</td>
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</tbody>
</table>

Also available in submerged arc.

MECHANICAL PROPERTIES
Hardness: 59-63 Rc as welded

CLASSIFICATION
M-1 type tool steel