COR™FACE 84 MC

DESCRIPTION
COR™FACE 84 MC is a metal-cored, hardfacing wire designed to resist abrasion, corrosion, and impact at elevated temperatures. The minimal slag content offers increased productivity over powder deposits and cast rods.

APPLICATIONS
84 MC is typically used for overlaying hot extrusion dies, trimmers, punches, hot shear blades, glass molds and plastic extrusion screws.

PROCEDURE
Preheat and post heat at 600-700°F to minimize cracking.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Shielding Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>MC-G .045”</td>
<td>19-24</td>
<td>160-200</td>
<td>75%Ar-25%CO₂</td>
</tr>
<tr>
<td>MC-G 1/16”</td>
<td>20-25</td>
<td>175-225</td>
<td>75%Ar-25%CO₂</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

Hardness: 35-45 Rc, 1 pass
35-45 Rc, 2 passes
45-50 Rc, undiluted buildup

Actual hardness depends on dilution. Verify hardness vs. welding parameters.

CLASSIFICATION
AWS A5.21, Class ERCNiCr-A