COR™FACE 85 MC

DESCRIPTION
COR™FACE 85 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. See also COR™FACE 84 and COR™FACE 86 for weld deposits that are softer and harder respectively.

APPLICATIONS
85 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>Size Volts</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>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>20-25</td>
<td>175-225</td>
<td>75%Ar-25%CO₂</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES
Hardness: 40-50 Rc, 1 pass
40-50 Rc, 2 passes
Actual hardness depends on dilution. Verify hardness vs. welding parameters.
50-55 Rc, undiluted buildup

CLASSIFICATION
AWS A5.21, Class ERNiCr-B