COR™ FACE 161 MC

DESCRIPTION
COR™ FACE 161 MC is a metal-cored, economical, wear-resistant alloy designed to combat abrasion at elevated temperatures. 161 MC employs a 430 stainless steel sheath with a lusty addition of tungsten carbide particles.

APPLICATIONS
161 MC is typically used for overlaying carbon, and low alloy steels. The welded deposit has approximately 8% chromium for resistance to abrasion at temperatures up to 1000°F.

PROCEDURE
Hardfacing generally does not require any heat treatment. Preheat and post-heat according to the base metal requirements where necessary.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Shielding Gas/Flux</th>
</tr>
</thead>
<tbody>
<tr>
<td>MC-G 1/16”</td>
<td>20-23</td>
<td>210-250</td>
<td>100%Ar or 75%Ar-25%CO₂</td>
</tr>
<tr>
<td>MC-G 3/32”</td>
<td>24-28</td>
<td>250-400</td>
<td>100%Ar or 75%Ar-25%CO₂</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

Hardness:
Matrix: 60 Rc
WC Particles: 2600 Knoop (no Rc conversion available)

CLASSIFICATION
Cr steel hardfacing alloy