COR™TOOL D2 MC

DESCRIPTION
COR™TOOL D2 MC is a metal-cored, air hardening AISI D2 alloy available in gas shielded, and TIG wires. The weld deposit is fully heat treatable.

APPLICATIONS
D2 MC is typically used for the repair and reclamtion of D2 parts, and upgrading AISI A-series tool steels. It is also well suited for coldworking applications such as shears, punches, slitters, and the composite fabrication of blanking and forming dies.

PROCEDURE
A minimum preheat/interpass temperature of 600°F is recommended for AISI D2. Refer to the AISI D2 procedure for a full heat treatment. This alloy will not provide peak performance without a full heat treatment!

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 .045”</td>
<td>20-22</td>
<td>160-180</td>
<td>75%Ar-25%CO₂</td>
</tr>
<tr>
<td>MC-G 1/16”</td>
<td>21-23</td>
<td>160-200</td>
<td>75%Ar-25%CO₂</td>
</tr>
</tbody>
</table>

MC-T TIG wires are available in .045”-3/32”.

MECHANICAL PROPERTIES

Hardness: 38-42 as welded
58-62 Rc heat-treated

CLASSIFICATION
AISI D2