COR™ TOOL H12 MC

DESCRIPTION
COR™ TOOL H12 MC is a metal-cored, H-12 hot work alloy designed to provide wear resistant deposits. This alloy performs especially well when rebuilding worn edges of hot trim dies.

APPLICATIONS
H12 MC is typically used to repair and rebuild H-12 tool steel and dies: forging, coining, and header dies, punches, extrusion mandrels, and tong bits. H12 MC also displays excellent cold work properties required for: forming and blanking dies, sledgehammer faces, and cutting edges for hatchets and punches.

PROCEDURE
A minimum preheat/interpass temperature of 850°F is recommended for hot work dies. Peen between passes for optimum performance. Post heat at 850°F for 3 hours after welding, then allow the deposit to cool below 200°F. Temper to desired hardness according to the temper chart for 1 hour/inch thickness. For a full heat treatment, refer to the AISI H-12 procedure.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Type</th>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Shielding Gas/Flux</th>
</tr>
</thead>
<tbody>
<tr>
<td>MC-G</td>
<td>.045&quot;</td>
<td>16-20</td>
<td>150-200</td>
<td>75%Ar-25%CO₂</td>
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</tbody>
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MECHANICAL PROPERTIES
50-55 Rc as welded

CLASSIFICATION
AISI H-12