COR™MAIN 11 FC

DESCRIPTION
COR™MAIN 11 FC is a flux-cored, iron based wire formulated to provide a wear resistant, machinable buildup and overlay on several types of cast iron. Also available as 1101 MC-G for weld deposits without slag cover.

APPLICATIONS
11 FC is used for welding flame-hardenable, automotive cast iron stamping and forming dies. 11 FC has also been used for building up drawing die wear surfaces, joining steel to cast iron, and repairing high alloy tool steel dies.

PROCEDURE
Preheat according to the base material. Peen each pass, and use a skip welding technique when building up large surfaces in order to minimize stresses and localized heat input.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
<th>Shielding Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>FC-G .045”</td>
<td>18-25</td>
<td>150-200</td>
<td>1/2”</td>
<td>75Ar-25CO₂</td>
</tr>
<tr>
<td>FC-G 1/16”</td>
<td>20-25</td>
<td>175-250</td>
<td>5/8”</td>
<td>75Ar-25CO₂</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

- Tensile: 150,000 psi
- Elongation: up to 35%
- Hardness: 30-35 Rc as welded
- 40+ Rc work hardened

CLASSIFICATION
Iron base, 15% alloy Ni-Cr-Mn-Mo