COR™FORGE F58 FC

DESCRIPTION
COR™FORGE F58 FC is a flux-cored, H-12 hot work alloy designed to provide wear resistant deposits.

APPLICATIONS
F58 is typically used to repair and rebuild H-12 and #2 tools and dies: forging, coining, and header dies, punches, extrusion mandrels, and tong bits. F58 also displays excellent cold work properties required for: forming and blanking dies, sledge hammer 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 while removing slag for optimum performance. Post heat at 850°F for 3 hours after welding, and 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>18-20</td>
<td>150-200</td>
<td>75%Ar-25%CO₂</td>
</tr>
<tr>
<td>FC-G</td>
<td>1/16&quot;</td>
<td>23-25</td>
<td>230-270</td>
<td>75%Ar-25%CO₂</td>
</tr>
<tr>
<td>FC-G</td>
<td>3/32&quot;</td>
<td>29-31</td>
<td>450-550</td>
<td>75%Ar-25%CO₂</td>
</tr>
</tbody>
</table>

Submerged arc wires are available in 1/16"-3/16"; Use a neutral flux.

MECHANICAL PROPERTIES
50-55 Rc as welded

CLASSIFICATION
AISI H-12