COR™FORGE F112 FC

DESCRIPTION
COR™FORGE F112 FC is a flux-cored, nickel-chrome-moly alloy designed for high temperature applications requiring strength and oxidation resistance. F112 FC offers a smooth, globular transfer and excellent controllability in the flat position.

APPLICATIONS
F112 FC is primarily used for overlaying press forging dies. It maintains strength at service temperatures up to 1500°F over extended contact periods.

PROCEDURE
Preheat and postheat according to the base material.

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>FC-G</td>
<td>.045”</td>
<td>25-27</td>
<td>150-190</td>
<td>75%Ar-25CO₂</td>
</tr>
<tr>
<td>FC-G</td>
<td>1/16”</td>
<td>23-26</td>
<td>175-225</td>
<td>75%Ar-25CO₂</td>
</tr>
<tr>
<td>FC-G</td>
<td>3/32”</td>
<td>25-27</td>
<td>275-350</td>
<td>75%Ar-25CO₂</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES
Tensile Strength: 100,000 psi
Elongation: 30%

CLASSIFICATION
Chrome-Moly-Columbium Nickel Base Alloy