COR™FORGE F1122 FC

DESCRIPTION
COR™FORGE F1122 FC is a flux-cored, nickel-chrome-moly alloy designed for high temperature applications requiring strength and oxidation resistance. F1122 FC offers a smooth, globular transfer and excellent controllability in the flat position.

APPLICATIONS
F1122 FC is primarily used for high-temperature forging equipment. It maintains strength at service temperatures up to 1500°F over extended contact periods. Typical uses include mandrels and rings dies.

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>1/16&quot;</td>
<td>23-26</td>
<td>175-225</td>
<td>75Ar-25CO₂</td>
</tr>
<tr>
<td>FC-G</td>
<td>3/32&quot;</td>
<td>25-27</td>
<td>275-350</td>
<td>75Ar-25CO₂</td>
</tr>
</tbody>
</table>

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

CLASSIFICATION
Chrome-Moly-Tungsten Nickel Base Alloy