

COR™FORGE F15 ELECTRODE

DESCRIPTION

COR™FORGE F15 is a chrome-nickel-moly, iron base electrode designed for underlaying, primarily in the repair and reclamation of forging dies. The welding characteristics facilitate flood welding and continuous multipassing.

APPLICATIONS

In addition to forging applications, F15 is an excellent plant maintenance electrode, providing 125,000 psi tensile strength fabricating welds, i.e. repair of heavy equipment. The undiluted weld deposits are fully machinable.

PROCEDURE

A minimum preheat/interpass temperature of 800°F is recommended for forging dies. Post heat at 800°F for 3 hours after welding, and then allow the deposit to cool below 200°F. Temper at 1050°F for 1 hour/inch thickness. Preheat and post heat according to the base material for all other applications.

WELDING PARAMETERS

Size	3/32"	1/8"	5/32"	3/16"	1/4"
Amps	75-100	105-130	145-160	180-200	240-260

MECHANICAL PROPERTIES AFTER 1050°F TEMPER, 10 HOURS

Hardness: 15-20 Rc
 Tensile: 115,000 psi
 Yield: 90,000 psi
 Elongation: 25%
 R.A.: 68%

CLASSIFICATION

Chrome-Nickel-Moly Iron base alloy