COR™FORGE F58 ELECTRODE

DESCRIPTION
COR™FORGE F58 is an H-12 hot work electrode 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.

MECHANICAL PROPERTIES
1050°F TEMPER, 10 HOURS
Hardness: 50-55 Rc

WELDING PARAMETERS
<table>
<thead>
<tr>
<th>Size</th>
<th>3/32&quot;</th>
<th>1/8&quot;</th>
<th>5/32&quot;</th>
<th>3/16&quot;</th>
<th>1/4&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Amps</td>
<td>75-100</td>
<td>105-130</td>
<td>145-160</td>
<td>180-200</td>
<td>240-260</td>
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</tbody>
</table>

CLASSIFICATION
AISI H-12