

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.

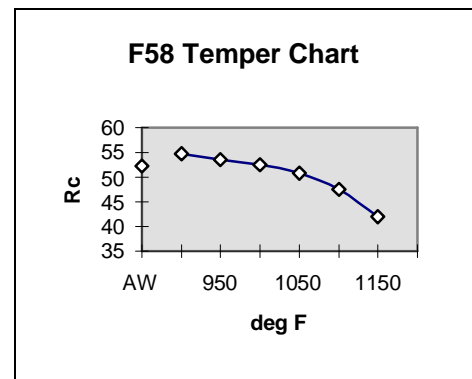
PROCEDURE

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

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

CLASSIFICATION

AISI H-12