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COR™FORGE F63 ELECTRODE

DESCRIPTION

COR™FORGE F63 is a 9% chrome hot work electrode designed for hammer and press die forging applications. F63 maintains integrity when subjected to high heat and stresses. The welding characteristics allow flood welding and continuous multiple passes. Weld deposits are fully machinable.

APPLICATIONS

F63 is typically used to repair and rebuild shallow hammer dies with high duty cycles, and press forging die impressions requiring machinable welds.

PROCEDURE

A minimum preheat/interpass temperature of 900°F is recommended for hot work dies. Post heat at 900°F for 3 hours after welding, and then allow the deposit to cool below 200°F. Temper according to the temper chart 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 TEMPER, 10 HOURS

Temperature	Hardness
950	43-47
1000	40-44
1050	38-42

CLASSIFICATION

9% Chrome Hot Work Tool Steel