COR™FORGE F112 ELECTRODE

DESCRIPTION
COR™FORGE F112 is a nickel-chrome-moly electrode designed for high temperature forging applications requiring strength and oxidation resistance. F112 offers an easily removable slag, and excellent controllability in the flat, and horizontal positions.

APPLICATIONS
F112 is primarily used for overlaying press forging dies. It maintains strength at service temperatures up to 1500°F over extended contact periods.

PROCEDURE
Preheat and postheat according to the base material.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>3/32”</th>
<th>1/8”</th>
<th>5/32”</th>
<th>3/16”</th>
<th>1/4”</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>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

- Tensile Strength: 100,000 psi
- Elongation: 30%

CLASSIFICATION

Chrome-Moly-Columbium Nickel Base Alloy