COR™FORGE 2101 ELECTRODE

DESCRIPTION
COR™FORGE 2101 is a cobalt base alloy electrode designed for improved resistance to impact, thermal fatigue, and corrosion at temperatures exceeding 1500° F. 2101 E is not used for severe abrasion applications, but the weld deposit exhibits superior resistance to heat checking, spalling, chipping, and erosion over COR™BAL 21.

APPLICATIONS
Typical hot work applications include: impressions in forging dies, trimming dies, high temperature valves, punches, shear blades, and extrusion dies. 2101 FC is also used to overlay parts subject to oxidizing and reducing atmospheres at temperatures up to 2100° F.

PROCEDURE
A minimum preheat of 350° F is recommended for mild steels. Preheat all other alloys according to the base material.

WELDING PARAMETERS

<table>
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<tr>
<th>Size</th>
<th>1/8”</th>
<th>5/32”</th>
<th>3/16”</th>
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<tr>
<td>Amps</td>
<td>125</td>
<td>150</td>
<td>180</td>
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MECHANICAL PROPERTIES
35-38 Rc as welded, 45+ Rc work hardened

CLASSIFICATION
Cr-Mo-Cb Cobalt base alloy