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## COR™FACE 86 MC

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### DESCRIPTION

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COR™FACE 86 MC is a metal-cored, hardfacing wire designed to resist severe abrasion, particularly high stress, metal-to-metal wear. 86 MC also resists corrosion at elevated temperatures, and the minimal slag content offers increased productivity over powder deposits and cast rods.

### APPLICATIONS

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86 MC is typically used for mill guides, valve components, and plastic extrusion screws.

### PROCEDURE

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Preheat and post heat at 700°F to minimize cracking.

### WELDING PARAMETERS

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Size	Volts	Amps	Shielding Gas
MC-G .045"	19-24	160-200	75%Ar-25%CO <sub>2</sub>
MC-G 1/16"	20-25	175-225	75%Ar-25%CO <sub>2</sub>

### MECHANICAL PROPERTIES

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Hardness: 50-60 Rc, 1 pass  
50-60 Rc, 2 passes  
Actual hardness depends on dilution. Verify hardness vs. welding parameters.  
60-65 Rc, undiluted buildup

### CLASSIFICATION

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AWS A5.21, Class 5.21 ERCNiCr-C