

COR™FACE 62 FC

DESCRIPTION

COR™FACE 62 FC is a M2 high speed tool steel wire. This alloy is available as a metal cored(MC) and as a flux cored(FC) depending on the size. 62 FC yields a crack-free weld deposit which resists abrasion comparably to hardfacing alloys, and maintains hardness at temperatures up to 1100°F.

APPLICATIONS

COR™FACE 62 FC is mainly used to repair and reclaim AISI M-1 and M-2 high-speed tool steels. It is also used to build composite parts, or give an M2 wear surface on a less expensive base material. Typical applications include repairing broaches and drills, cutting edges on piercing, blanking, and trimming dies, and hardfacing earth moving equipment.

PROCEDURE

For repair of tool steel, maintain a preheat/interpass temperature of 1000°F. Peen each bead while still forgeable. Cool to room temperature. Temper at 1000°F for 1 hour/inch thickness. A second temper at 950°F is recommended. Use an AISI M-2 procedure for a full heat treatment. No heat treatment is required for hardfacing applications.

WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shielding Gas
MC-G .045"	18-28	120-250	1/2"	Ar-CO ₂ gas mixtures
MC-G 1/16"	20-30	200-300	3/4"	Ar-CO ₂ gas mixtures
FC-G 3/32"	25-30	300-400	3/4"	Ar-CO ₂ gas mixtures
FC-G 7/64"	25-30	350-450	3/4"	Ar-CO ₂ gas mixtures

Wires are also available for submerged arc in most sizes.

MECHANICAL PROPERTIES

Hardness: 59-63 Rc as welded

CLASSIFICATION

AISI M-2 tool steel