



COR-MET, INC.
12500 GRAND RIVER ROAD
BRIGHTON, MI 48116-8326
(810) 227-3251
800-848-2719
FAX: (810) 227-9266
www.cor-met.com

CORTMFACE 9544 FC

DESCRIPTION

CORTMFACE 9544 FC is a flux-cored, self-shielded, work hardening wire designed to resist impact and abrasion. This chrome-manganese wire could be classified as "Hadfield" steel, and will also withstand considerable heat input without embrittling.

APPLICATIONS

9544 FC is typically used for joining manganese steel to manganese, carbon, and low alloy steels. Specific uses include: crusher rolls and cones, railroad frogs and crossings, bucket teeth, and impact hammers.

PROCEDURE

Preheat according to base material. Do not exceed 600 deg F.

WELDING PARAMETERS

Size	Volts	Amps	Stickout
FC-O .045"	24-26	120-180	1"
FC-O 1/16"	25-29	180-220	1.25"
FC-O 3/32"	26-30	270-330	1.5"
FC-O 1/8"	27-31	375-450	1.5"

MECHANICAL PROPERTIES

Hardness: 20 Rc as welded
45+ Rc work hardened
Tensile Strength: 140,000 psi
Yield Strength: 90,000 psi
Elongation: 25%

CLASSIFICATION

Iron base Cr-Mn steel