

## COR™TOOL D2 MC

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### DESCRIPTION

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COR™TOOL D2 MC is a metal-cored, air hardening AISI D2 alloy available in gas shielded, and TIG wires. The weld deposit is fully heat treatable.

### APPLICATIONS

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D2 MC is typically used for the repair and reclamation of D2 parts, and upgrading AISI A-series tool steels. It is also well suited for coldworking applications such as shears, punches, slitters, and the composite fabrication of blanking and forming dies.

### PROCEDURE

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A minimum preheat/interpass temperature of 600°F is recommended for AISI D2. Refer to the AISI D2 procedure for a full heat treatment. This alloy will not provide peak performance without a full heat treatment!

### WELDING PARAMETERS

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Size	Volts	Amps	Shielding Gas/Flux
MC-G .045"	20-22	160-180	75%Ar-25%CO <sub>2</sub>
MC-G 1/16"	21-23	160-200	75%Ar-25%CO <sub>2</sub>

MC-T TIG wires are available in .045"-3/32".

### MECHANICAL PROPERTIES

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Hardness:           38-42 as welded  
                           58-62 Rc heat-treated

### CLASSIFICATION

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AISI D2