

## **COR™TOOL S7 MC**

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### **DESCRIPTION**

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COR™TOOL S7 MC is a metal-cored, shock resistant AISI S-7 alloy, and is available in gas shielded, and TIG wires.

### **APPLICATIONS**

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S7 MC is typically used for the repair and reclamation of AISI S-series shock resistant tool steels. It is also well suited for coldworking applications, and the composite fabrication of blanking, trimmer, header and brake dies.

### **PROCEDURE**

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A minimum preheat/interpass temperature of 600-800°F is recommended for AISI S-7. Peening is recommended. Allow the welded part to cool as slow as possible. Temper at 600°F for one hour per inch thickness. Refer to the AISI S-7 procedure for 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>

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### **MECHANICAL PROPERTIES**

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Hardness: 54-58 Rc as welded

### **CLASSIFICATION**

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AISI S-7