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CORTMMAIN 11 FC

DESCRIPTION

CORTMMAIN 11 FC is a flux-cored, iron based wire formulated to provide a wear resistant, machinable buildup and overlay on several types of cast iron. Also available as 1101 MC-G for weld deposits without slag cover.

APPLICATIONS

11 FC is used for welding flame-hardenable, automotive cast iron stamping and forming dies. 11 FC has also been used for building up drawing die wear surfaces, joining steel to cast iron, and repairing high alloy tool steel dies.

PROCEDURE

Preheat according to the base material. Peen each pass, and use a skip welding technique when building up large surfaces in order to minimize stresses and localized heat input.

WELDING PARAMETERS

	Size	Volts	Amps	Stickout	Shielding Gas
FC-G	.045"	18-25	150-200	1/2"	75Ar-25CO ₂
FC-G	1/16"	20-25	175-250	5/8"	75Ar-25CO ₂

MECHANICAL PROPERTIES

Tensile: 150,000 psi
Elongation: up to 35%
Hardness: 30-35 Rc as welded
40+ Rc work hardened

CLASSIFICATION

Iron base, 15% alloy Ni-Cr-Mn-Mo