

COR™MAIN 68 FC

DESCRIPTION

COR™MAIN 68 FC is a flux-cored, high chrome wire designed as a heat treatable tool steel repair alloy. The weld deposits will resist oxidation and corrosion up to 1200°F.

APPLICATIONS

68 FC is typically used for joining cracked tools, dies, and fixtures that may or may not require heat treatment. The as-welded deposit exhibits a low coefficient of friction, making it ideal for building up shafts, bearing surfaces, and valves. 68 FC is ideally suited for high temperature applications such as steam turbine buckets, blades, and covers.

PROCEDURE

Preheat according to base material. Peening is recommended to bring compressive stresses to the surface.

WELDING PARAMETERS

Type	Size	Volts	Amps	Stickout	Shielding Gas
MC-G	.045"	21-23	140-180	1/2"	75%Ar-25%CO ₂
FC-G	1/16"	24-26	250-300	1/2"	75%Ar-25%CO ₂
FC-G	3/32"	27-29	375-425	3/4"	75%Ar-25%CO ₂
FC-G	1/8"	29-31	550-650	3/4"	75%Ar-25%CO ₂

MECHANICAL PROPERTIES

Hardness: 36-40 Rc as welded
 Tensile Strength: 160,000 psi

CLASSIFICATION:

Iron base Cr-Ni steel