

COR™FORGE F45 ELECTRODE

DESCRIPTION

COR™FORGE F45 is a chrome-nickel-moly, iron base electrode designed for forging and press die applications. The welding characteristics allow flood welding and continuous multiple passes.

APPLICATIONS

Typically used to repair and rebuild die impressions requiring a hardness of 41-46 Rc. F45 is also used as an underlay in press die applications.

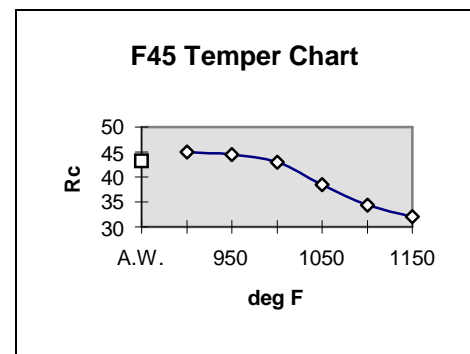
PROCEDURE

A minimum preheat/interpass temperature of 800°F is recommended for forging dies. Post heat at 800°F for 3 hours after welding, and then allow the deposit to cool below 200°F. Temper according to the temper chart for 1 hour/inch thickness. Preheat and post heat according to the base material for all other applications.

MECHANICAL PROPERTIES

1050°F TEMPER, 10 HOURS

Hardness: 41-46 Rc
Tensile: 185,000 psi
Yield: 170,000 psi
Elongation: 12%
R.A.: 40%



WELDING PARAMETERS

Size	3/32"	1/8"	5/32"	3/16"	1/4"	5/16"	3/8"
Amps	70	90	130	160	220	300	350
	-100	-130	-180	-200	-270	-450	-500

CLASSIFICATION

Chrome-Nickel-Moly Iron Base Alloy