

COR™FORGE F54 ELECTRODE

DESCRIPTION

COR™FORGE F54 is a hot work electrode designed to provide wear resisting deposits which are fully machinable. F54 has exceptionally smooth arc characteristics and an easily removable slag, regardless of heat input.

APPLICATIONS

F54 is typically used to repair and rebuild press forging die impressions, upsetter insert dies, and any AISI hot work tool steels requiring machinable welds.

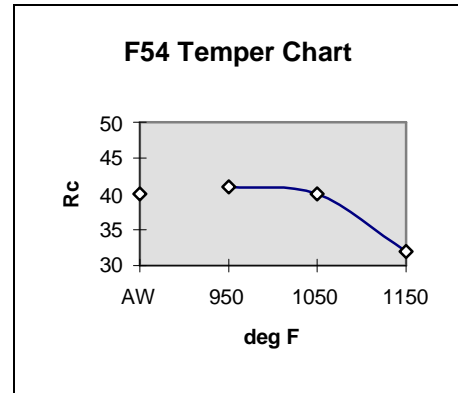
PROCEDURE

A minimum preheat/interpass temperature of 900°F is recommended for hot work dies. Peen between passes while removing slag for optimum performance. Post heat at 900°F for 3 hours after welding, and then allow the deposit to cool below 200°F. Temper to desired hardness 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: 38-42 Rc



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

5% Chrome Hot Work Tool Steel