

COR™FORGE F580 ELECTRODE

DESCRIPTION

COR™FORGE F580 is a modified H-12 hot work electrode designed to provide weld deposits with superior hot hardness, and wear resistance.

APPLICATIONS

F580 is primarily used to repair and rebuild flash lines on press forging dies, and is also used to overlay shallow impression dies. This alloy is not suited for thick weldments. A 3/8" overlay would be the maximum.

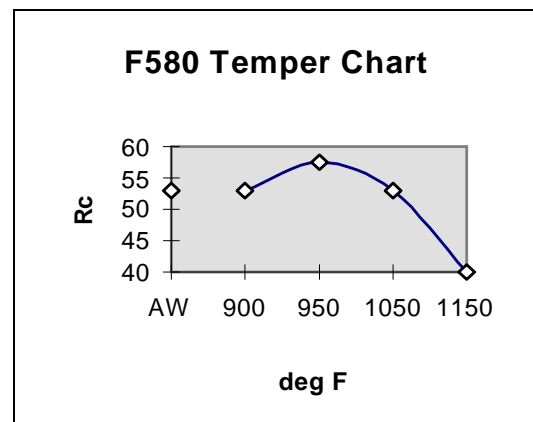
PROCEDURE

A minimum preheat/interpass temperature of 850°F is recommended for hot work dies. Peen between passes while removing slag for optimum performance. Post heat at 850°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.

MECHANICAL PROPERTIES

1050°F TEMPER, 10 HOURS

Hardness: 53-58 Rc



WELDING PARAMETERS

Size	3/32"	1/8"	5/32"	3/16"	1/4"
Amps	75-100	105-130	145-160	180-200	240-260

CLASSIFICATION

Modified AISI H-12