

## **COR™FORGE F64 ELECTRODE**

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### **DESCRIPTION**

COR™FORGE F64 is a 11% chrome hot work electrode designed to outperform 5% chrome grades in applications requiring resistance to heat and abrasion. The welding characteristics allow flood welding and continuous multiple passes. Weld deposits are difficult to machine. Machining by EDM is recommended.

### **APPLICATIONS**

F64 is typically used on steel mill components, overlays on aluminum die casters, and open forging dies used for titanium and other exotic alloys. It can be used on closed dies to resist heavy abrasion.

### **PROCEDURE**

Maintain a preheat/interpass temperature of 800-1000°F. Post heat at 1050°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. A second temper at 50°F below the first is recommended. Use an AISI H-12 procedure for a full heat treatment.

### **WELDING PARAMETERS**

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

### **MECHANICAL PROPERTIES AFTER TEMPER, 10 HOURS**

Temperature	Hardness
950	45-49
1000	42-46
1050	39-43

### **CLASSIFICATION**

11% Chrome Hot Work Tool Steel