

COR™FORGE F65 ELECTRODE

DESCRIPTION

COR™FORGE F65 is a 9% chrome hot work electrode designed for hammer and press die applications. F65 maintains integrity when subjected to high heat and stresses. The weld metal can be tempered to a final hardness range of 40-50 Rc.

APPLICATIONS

F65 is typically used to repair and rebuild shallow hammer dies with high duty cycles, and press forging die impressions requiring machinable welds.

PROCEDURE

A minimum preheat/interpass temperature of 900°F is recommended for hot work dies. Post heat at 900°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.

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	52-55
1000	49-52
1050	44-47

CLASSIFICATION

9% Chrome Hot Work Tool Steel