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COR™FORGE F112 ELECTRODE

DESCRIPTION

COR™FORGE F112 is a nickel-chrome-moly electrode designed for high temperature forging applications requiring strength and oxidation resistance. F112 offers an easily removable slag, and excellent controllability in the flat, and horizontal positions.

APPLICATIONS

F112 is primarily used for overlaying press forging dies. It maintains strength at service temperatures up to 1500°F over extended contact periods.

PROCEDURE

Preheat and postheat according to the base material.

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

Tensile Strength: 100,000 psi
Elongation: 30%

CLASSIFICATION

Chrome-Moly-Columbium Nickel Base Alloy