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CORTMFACE 85 MC

DESCRIPTION

CORTMFACE 85 MC is a metal-cored, hardfacing wire designed to resist abrasion, corrosion, and impact at elevated temperatures. The minimal slag content offers increased productivity over powder deposits and cast rods. See also CORTMFACE 84 and CORTMFACE 86 for weld deposits that are softer and harder respectively.

APPLICATIONS

85 MC is typically used for overlaying hot extrusion dies, trimmers, punches, hot shear blades, glass molds, and plastic extrusion screws.

PROCEDURE

Preheat and post heat at 600-700°F to minimize cracking.

WELDING PARAMETERS

Size	Volts	Amps	Shielding Gas
MC-G .045"	19-24	160-200	75%Ar-25%CO ₂
MC-G 1/16"	20-25	175-225	75%Ar-25%CO ₂

MECHANICAL PROPERTIES

Hardness: 40-50 Rc, 1 pass
40-50 Rc, 2 passes
Actual hardness depends on dilution. Verify hardness vs. welding parameters.
50-55 Rc, undiluted buildup

CLASSIFICATION

AWS A5.21, Class ERNiCr-B