

## COR™TOOL H12 MC

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### DESCRIPTION

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COR™TOOL H12 MC is a metal-cored, H-12 hot work alloy designed to provide wear resistant deposits. This alloy performs especially well when rebuilding worn edges of hot trim dies.

### APPLICATIONS

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H12 MC is typically used to repair and rebuild H-12 tool steel and dies: forging, coining, and header dies, punches, extrusion mandrels, and tong bits. H12 MC also displays excellent cold work properties required for: forming and blanking dies, sledgehammer faces, and cutting edges for hatchets and punches.

### PROCEDURE

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A minimum preheat/interpass temperature of 850°F is recommended for hot work dies. Peen between passes for optimum performance. Post heat at 850°F for 3 hours after welding, then allow the deposit to cool below 200°F. Temper to desired hardness according to the temper chart for 1 hour/inch thickness. For a full heat treatment, refer to the AISI H-12 procedure.

### WELDING PARAMETERS

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Type	Size	Volts	Amps	Shielding Gas/Flux
MC-G	.045"	16-20	150-200	75%Ar-25%CO <sub>2</sub>

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### MECHANICAL PROPERTIES

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50-55 Rc as welded

### CLASSIFICATION

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AISI H-12