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## COR<sup>TM</sup>FORGE F112 FC

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### DESCRIPTION

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COR<sup>TM</sup>FORGE F112 FC is a flux-cored, nickel-chrome-moly alloy designed for high temperature applications requiring strength and oxidation resistance. F112 FC offers a smooth, globular transfer and excellent controllability in the flat position.

### APPLICATIONS

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

### PROCEDURE

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Preheat and postheat according to the base material.

### WELDING PARAMETERS

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Type	Size	Volts	Amps	Shielding Gas/Flux
FC-G	.045"	25-27	150-190	75%Ar-25CO <sub>2</sub>
FC-G	1/16"	23-26	175-225	75%Ar-25CO <sub>2</sub>
FC-G	3/32"	25-27	275-350	75%Ar-25CO <sub>2</sub>

### MECHANICAL PROPERTIES

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Tensile Strength: 100,000 psi  
Elongation: 30%

### CLASSIFICATION

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Chrome-Moly-Columbium Nickel Base Alloy