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## COR™FORGE F110 ELECTRODE

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### DESCRIPTION

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COR™FORGE F110 is nickel based alloy designed for optimum welder appeal, including smooth arc action, fluid puddle, and a full slag which is easily removed. F110 FC is alloyed with chromium, molybdenum, and tungsten for resistance to heat and impact. Weld deposits are also corrosion resistant, work hardenable, and retain their strength up to 1000°F.

### APPLICATIONS

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F110 is used for overlaying Hastelloy®C, hot forge dies, trimmers and punches, hot shear blades, extrusion dies, and blast furnace bleeder valves. It may also be used for tong bits, pump shafts, valve seats, shaft sleeves, and impellers.

### PROCEDURE

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Preheat according to base material: 350°F for low alloy steels; 600°F minimum for heat treatable steels. Mild steels do not require post-weld heat treatment. Heat treatable steels should be tempered according to the base material. If no guidelines are available, then temper at 1000°F and cool in still air.

### WELDING PARAMETERS

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Size	3/32"	1/8"	5/32"	3/16"	1/4"
Amps	75-100	105-130	145-160	180-200	240-260

### MECHANICAL PROPERTIES

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20-25 Rc as welded  
Work hardens to 38+ Rc

### CLASSIFICATION

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AWS A5.11, class ENiCrMo-5

Hastelloy is a registered trademark of Cabot Corporation