COR™NICKEL N100A FC

DESCRIPTION
COR™NICKEL N100A FC is a flux-cored, nickel base alloy formulated for superior welder appeal and bead appearance. The N100A FC offers improved wetout, excellent slag removal, and an X-ray quality weld. This combination provides an easy adaptation to automatic and semi-automatic applications, resulting in increased productivity over conventional shielded metal arc welding electrodes and solid wires.

APPLICATIONS
N100A FC is used for joining nickel-chromium-iron alloys, 9% nickel steel, and a variety of dissimilar metal combinations including: carbon steel, stainless steel, and nickel alloys. N100A maintains strength and oxidation resistance at service temperatures from cryogenic to 1500°F.

PROCEDURE
Keep preheat and postheat to a minimum or according to base material.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
<th>Shielding Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>FC-G</td>
<td>.045&quot;</td>
<td>24-28</td>
<td>120-200</td>
<td>CO₂ or Ar-CO₂ mixtures</td>
</tr>
<tr>
<td>FC-G</td>
<td>1/16&quot;</td>
<td>22-28</td>
<td>150-250</td>
<td>CO₂ or Ar-CO₂ mixtures</td>
</tr>
<tr>
<td>FC-G</td>
<td>3/32&quot;</td>
<td>23-28</td>
<td>300-400</td>
<td>CO₂ or Ar-CO₂ mixtures</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES
Tensile Strength: 80,000 psi minimum
Elongation: 25% minimum

CLASSIFICATION
AWS A5.34 TNi 6133-01/4 ENiCrFe2TO-1/4