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COR™NICKEL N102 FC

DESCRIPTION

COR™NICKEL N102 is a multipurpose, nickel base electrode formulated for superior welder appeal and bead appearance. The N102 offers excellent welding characteristics for a wide range of applications.

APPLICATIONS

N102 is used for joining nickel-chromium-molybdenum alloys, such as Hastelloy X and HX. N102 maintains strength, ductility, and oxidation resistance at service temperatures to 1600°F for extended periods. Exposure to service temperatures above 1600°F can be sustained for shorter periods of time. N102 also shows resistance to stress corrosion cracking in petrochemical applications.

PROCEDURE

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

WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shielding Gas
.045	24-26	110-140	1/2"	75Ar-25CO ₂
1/16"	25-28	200-240	1/2"	75Ar-25CO ₂

MECHANICAL PROPERTIES

Tensile Strength: 90,000 psi minimum
Elongation: 25% minimum

CLASSIFICATION

AWS A5.34 TNi 6002-01/4 ENiCrMo2TO-1/4