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

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
<th>Shielding Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>.045</td>
<td>24-26</td>
<td>110-140</td>
<td>1/2”</td>
<td>75Ar-25CO₂</td>
</tr>
<tr>
<td>1/16”</td>
<td>25-28</td>
<td>200-240</td>
<td>1/2”</td>
<td>75Ar-25CO₂</td>
</tr>
</tbody>
</table>

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

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