COR\textsuperscript{TM} NICKEL N276 FC

DESCRIPTION
COR\textsuperscript{TM} NICKEL N276 FC is a flux-cored, nickel base alloy designed for optimum welder appeal, including smooth arc action, fluid puddle, and a full slag which is easily removed. N276 FC is alloyed with chromium, molybdenum, and tungsten for corrosion and oxidation resistance at elevated temperatures. A low carbon content ensures good ductility and crack resistance when used for fabrication.

APPLICATIONS
N276 FC is used to join Hastelloy\textsuperscript{®} C-276 components, nickel alloys, and stainless steels. This alloy is best used in applications requiring resistance to crevice and pitting corrosion.

PROCEDURE
Preheat according to base material: 350\textdegree F for low alloy steels; 600\textdegree 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\textdegree F and cool in still air.

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 .045”</td>
<td>24-28</td>
<td>120-200</td>
<td>1/2”</td>
<td>CO\textsubscript{2} or Ar-CO\textsubscript{2} mixtures</td>
</tr>
<tr>
<td>FC-G 1/16”</td>
<td>22-28</td>
<td>150-250</td>
<td>3/4”</td>
<td>CO\textsubscript{2} or Ar-CO\textsubscript{2} mixtures</td>
</tr>
<tr>
<td>FC-G 3/32”</td>
<td>23-28</td>
<td>300-400</td>
<td>3/4”</td>
<td>CO\textsubscript{2} or Ar-CO\textsubscript{2} mixtures</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

- Tensile Strength: 100,000 psi minimum
- Elongation: 25% minimum

CLASSIFICATION

AWS A5.34 TNi 6276-01/4 ENiCrMo4TO-1/4

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