COR™ NICKEL N625L FC

DESCRIPTION
COR™ NICKEL N625L FC is a flux-cored, nickel base alloy, which maintains strength up to 1500°F, and resists corrosion up to 1800°F. This material produces an undiluted weld deposit of 1.0% maximum Fe.

APPLICATIONS
N625L FC is used for overlaying steel, welding various nickel alloys i.e. nickel steels, Monels®, Inconels®, Incoloy®, and various corrosion resistant alloys. N625L is also an excellent choice for joining stainless since it supplies the supplemental molybdenum required to prevent pitting corrosion.

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

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Type</th>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
<th>Shielding Gas/Flux</th>
</tr>
</thead>
<tbody>
<tr>
<td>FC-G</td>
<td>.045&quot;</td>
<td>25-32</td>
<td>150-250</td>
<td>1/2&quot;</td>
<td>CO₂ or Ar-CO₂ mixtures</td>
</tr>
<tr>
<td>FC-G</td>
<td>1/16&quot;</td>
<td>23-30</td>
<td>150-300</td>
<td>1/2&quot;</td>
<td>CO₂ or Ar-CO₂ mixtures</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength</td>
<td>100,000 psi minimum</td>
</tr>
<tr>
<td>Elongation</td>
<td>25% minimum</td>
</tr>
</tbody>
</table>

CLASSIFICATION

AWS A5.34 TNi 6625-01/4 ENiCrMo3TO-1/4

©Inconel, Incoloy, and Monel are registered trademarks of Huntington Alloys.