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COR™NICKEL N22 FC

DESCRIPTION

COR™NICKEL N22 FC is a flux-cored, nickel base alloy designed to deliver smooth arc action, a fluid puddle, and a full slag which is easily removed. N22 FC is alloyed with chromium, molybdenum, and tungsten for ultimate corrosion and oxidation resistance at ambient to elevated temperatures. A low carbon content ensures good ductility and crack resistance when used for fabrication.

APPLICATIONS

N22 FC is used to join and repair nickel-chrome-moly alloys. This alloy will resist stress corrosion cracking, localized corrosion, and oxidizing and reducing chemicals and atmospheres. N22 is the most versatile alloy for applications requiring resistance to corrosion of weldments.

PROCEDURE

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

WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shielding Gas
FC-G .045"	24-28	120-200	1/2"	CO ₂ or Ar-CO ₂ mixtures
FC-G 1/16"	22-28	150-250	3/4"	CO ₂ or Ar-CO ₂ mixtures
FC-G 3/32"	23-28	300-400	3/4"	CO ₂ or Ar-CO ₂ mixtures

MECHANICAL PROPERTIES

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

CLASSIFICATION

AWS A5.34 TNi 6022-01/4 ENiCrMo10TO-1/4