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COR[®]NICKEL N82 FC

DESCRIPTION

COR[™]NICKEL N82 FC is a flux-cored, nickel base alloy with a variety of uses in the welding field. N82 FC has a very fluid weld puddle, superb slag removal, and outstanding bead appearance.

APPLICATIONS

N82 is an excellent choice for flux-cored arc welding of dissimilar alloy combinations, such as nickel to stainless, stainless to carbon steels, Inconel[®] 600, 601, and 690, INCOLOY[®] 800 AND 800HT and INCO[®]330. N82 can also be used to join nickel to Monel[®] alloys, and Monel[®] alloys to carbon steel. N82 maintains strength, and resists corrosion and oxidation up to 900°F.

PROCEDURE

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

WELDING PARAMETERS

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

MECHANICAL PROPERTIES

Tensile Strength: 80,000 psi minimum
Elongation: 30% minimum

CLASSIFICATION

AWS A5.34 TNi 6082-01/4 ENiCr3T0-1/4

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