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## COR™NICKEL N100A FC

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### DESCRIPTION

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COR™NICKEL N100A FC is a flux-cored, nickel base alloy formulated for superior welder appeal and bead appearance. The N100A FC offers improved wetout, excellent slag removal, and an X-ray quality weld. This combination provides an easy adaptation to automatic and semi-automatic applications, resulting in increased productivity over conventional shielded metal arc welding electrodes and solid wires.

### APPLICATIONS

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N100A FC is used for joining nickel-chromium-iron alloys, 9% nickel steel, and a variety of dissimilar metal combinations including: carbon steel, stainless steel, and nickel alloys. N100A maintains strength and oxidation resistance at service temperatures from cryogenic to 1500°F.

### PROCEDURE

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

### WELDING PARAMETERS

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

### MECHANICAL PROPERTIES

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Tensile Strength: 80,000 psi minimum  
Elongation: 25% minimum

### CLASSIFICATION

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AWS A5.34 TNi 6133-01/4 ENiCrFe2TO-1/4