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COR™ NICKEL N117 FC

DESCRIPTION

COR™ NICKEL N117 FC is a flux cored, nickel base alloy formulated for superior welder appeal and bead appearance. The N117 FC offers improved wetout and easy slag removal, resulting in increased productivity over conventional shielded metal arc welding electrodes and solid wires. The weld metal maintains high-temperature strength and oxidation resistance up to 2100°F.

APPLICATIONS

Typical applications for N117 FC include: joining Inconel® 600 and 601, Incoloy® 800HT and 802, and cast alloys HK-40, HP, and HP modified. This alloy performs best when welding nickel-chrome-iron alloys required to maintain strength and oxidation resistance above 1500°F.

PROCEDURE

Keep preheat and post heat to a minimum or according to base material.

WELDING PARAMETERS

Size	Volts	Amps	Shielding Gas
FC-G .045"	24-30	120-200	75%Ar-25%CO ₂
FC-G 1/16"	20-24	160-250	75%Ar-25%CO ₂
FC-G 3/32"	26-28	280-320	75%Ar-25%CO ₂

MECHANICAL PROPERTIES

Tensile Strength: 90,000 psi minimum
Elongation: 25% minimum

CLASSIFICATION

AWS A5.34 TNi 6117-01/4 ENiCrCoMo1TO-1/4

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