



COR-MET, INC.  
12500 GRAND RIVER ROAD  
BRIGHTON, MI 48116-8326  
(810) 227-3251  
800-848-2719  
FAX: (810) 227-9266  
[www.cor-met.com](http://www.cor-met.com)

## **COR™NICKEL N276 FC**

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### **DESCRIPTION**

COR™NICKEL N276 FC is a flux-cored, nickel base alloy designed for optimum welder appeal, including smooth arc action, fluid puddle, and a full slag which is easily removed. N276 FC is alloyed with chromium, molybdenum, and tungsten for corrosion and oxidation resistance at elevated temperatures. A low carbon content ensures good ductility and crack resistance when used for fabrication.

### **APPLICATIONS**

N276 FC is used to join Hastelloy® C-276 components, nickel alloys, and stainless steels. This alloy is best used in applications requiring resistance to crevice and pitting corrosion.

### **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 <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**

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

### **CLASSIFICATION**

AWS A5.34 TNi 6276-01/4 ENiCrMo4TO-1/4

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