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COR™NICKEL N625L FC

DESCRIPTION

COR™NICKEL N625L FC is a flux-cored, nickel base alloy, which maintains strength up to 1500°F, and resists corrosion up to 1800°F. This material produces an undiluted weld deposit of 1.0% maximum Fe.

APPLICATIONS

N625L FC is used for overlaying steel, welding various nickel alloys i.e. nickel steels, Monels®, Inconels®, Incolloys®, and various corrosion resistant alloys. N625L is also an excellent choice for joining stainless since it supplies the supplemental molybdenum required to prevent pitting corrosion.

PROCEDURE

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

WELDING PARAMETERS

Type	Size	Volts	Amps	Stickout	Shielding Gas/Flux
FC-G	.045"	25-32	150-250	1/2"	CO ₂ or Ar-CO ₂ mixtures
FC-G	1/16"	23-30	150-300	1/2"	CO ₂ or Ar-CO ₂ mixtures

MECHANICAL PROPERTIES

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

CLASSIFICATION

AWS A5.34 TNi 6625-01/4 ENiCrMo3TO-1/4

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