

COR™ALLOY 8620 FC

DESCRIPTION

COR™ALLOY 8620 FC is a flux-cored, AISI nickel-chrome-moly steel, and is readily available in gas shielded, self shielded, and sub-arc versions.

APPLICATIONS

8620 FC is typically used to join 100,000 psi tensile strength steel. It is an excellent buildup or joining material for wrought, cast, and forged AISI 8620 components. Specific uses include joining low alloy steels, pipe, and pressure vessels.

PROCEDURE

A minimum preheat/interpass temperature of 300-400°F is recommended for AISI 8620. Allow the welded part to cool as slow as possible in still air. Temper to desired hardness. Refer to the AISI 8620 procedure for a full heat treatment.

WELDING PARAMETERS

Size	Volts	Amps	Shielding Gas
MC-G .045"	18-30	150-250	CO ₂ or Ar-CO ₂ mixtures
MC-G 1/16"	20-22	200-250	CO ₂ or Ar-CO ₂ mixtures
FC-G 3/32"	26-29	250-350	CO ₂ or Ar-CO ₂ mixtures
FC-S 1/16"	25-27	150-250	Lincoln 880
FC-S 3/32"	29-31	300-400	Lincoln 880
FC-S 1/8"	29-31	350-450	Lincoln 880

MECHANICAL PROPERTIES

Hardness: 33-38 as welded

CLASSIFICATION

AISI 8620