

DESCRIPTION

Executive 117 FC is a nickel-chromium-cobalt-molybdenum gas shielded flux cored wire that has been formulated for superior welder appeal and good bead appearance. It is the flux cored equivalent to Executive 617, yet provides the ease of welding and increased deposition rates associated with flux cored wire, when used in the flat and horizontal position.

This wire offers very good wetout and easy slag removal, resulting in increased productivity when compared to solid wires and SMAW covered electrodes.

APPLICATIONS & FEATURES

Executive 117 FC is used for both joining and surfacing, in applications where optimum strength and oxidation resistance are required above 1500°F up to 2100°F.

It is best suited for welding on base metals of nickel-iron-chromium alloys such as Inconel® 600 and 601, Incoloy® 800HT and 802, and cast alloys HK-40, HP and HP modified.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	Cr	Ni	Mo	Co	Fe	P	S
0.09	1.1	0.5	23.0	BAL	8.5	10.0	0.5	0.01	0.01
Tensile Strength:		91,000 PSI min		Elongation:		25%			

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed (in./min)	Stick-Out	Shielding Gas
.045"	25-26	140-210	290-400 IPM	1/2"	100% CO ₂ or 75% Ar / 25% CO ₂
.062"	26-27	180-260	190-275 IPM	1/2"	100% CO ₂ or 75% Ar / 25% CO ₂

STANDARD PACKAGING

Spools 33-lb wire baskets

CLASSIFICATION

AWS/SFA A5.34, Class **ENiCrCoMo1T0-1/4**

*Inconel, Incoloy, and Monel are registered trademarks of Huntington Alloys.

