

DESCRIPTION

Executive 420 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 420 is a high-carbon stainless steel with 13% Cr and is designed to have high hardness (~50 HRC), great ductility after annealing, and excellent corrosion resistance after the surface has been prepared (hardened, ground, or polished).

APPLICATIONS & FEATURES

Executive 420 is used for build-up due to its excellent hardness and corrosion resistance.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.325	13.220	0.170	0.325	0.450	0.380	0.020	0.003	0.020	0.0276

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar
	.045"	22-23	180-210		
	.062"	23-24	200-220		
	.035"	23-25	190-260		
	.045"	25-28	250-330		
	.062"	28-31	310-350		
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IND 24 or Record IN
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER420**

