

DESCRIPTION

Executive 60 is a nickel-copper alloy designed for welding MONEL® alloys using TIG, MIG and SAW welding processes. This alloy is also used for weld overlay. The high alloy content of 70/30 produces weld material with good strength and corrosion resistance to reducing acids and seawater.

Executive 60 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand. Use Executive 70/30 where flux cored wire is more suited to the application.

APPLICATIONS & FEATURES

Executive 60 for joining MONEL® 400, R-405, and K-500, and copper alloys as well as dissimilar joints that include nickel-copper alloys, carbon steel and low alloy steel.

The Executive 60 is also suited for overlay of steels that require corrosion resistance to salts, reducing acids and seawater.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	Cr	Co	Mo
0.066	3.36	0.06	<0.001	<0.001	0.21	28.47	65.40	0.07	2.20	0.017	<0.001	<0.005

Tensile Strength: 70,000 PSI Min **Yield Strength:** **Elongation:** 30%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar
	.045"	19-22	75-160		75% Ar / 25% He
	- Spray	.045"	30-32		190-250
- Pulse	.045"	18-20	120-150		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.062"	28-32	250-280		NiCuW Flux
	.093"	28-33	275-350		
	.125"	29-34	350-450		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	
	60-lb Acro Pak	



CLASSIFICATION

AWS/SFA 5.14, Class **ERNiCu-7**