

DESCRIPTION

Executive 61 is a nickel alloy designed for welding alloy 200 and 201 using TIG, MIG and SAW welding processes. The high alloy content of Executive 61 produces weld material with good corrosion resistance, particularly in alkalies.

Executive 61 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.

APPLICATIONS & FEATURES

Executive 61 is used for joining alloy 200 and 201 as well as dissimilar joints between alloy 200 and 201.

Executive 61 is used for joining nickel 200 and 201 to Monel® and Inconel® alloys, stainless steels and carbon steel. It is also useful in joining copper-nickel alloys to Inconel® alloys as well as carbon steel.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti
0.003	0.253	0.110	0.006	0.001	0.168	0.002	95.447	0.447	3.489

Tensile Strength: 60,000 PSI Min **Yield Strength:** **Elongation:** 20%

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		NiCr-W 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 **ERNi-1**

