



#### DESCRIPTION

**Executive 56/21/14** is a nickel-chromium-molybdenum gas shielded FCAW wire that can be used for welding in all positions using 100% CO<sub>2</sub> or Argon/CO<sub>2</sub> mixtures. It is the flux cored equivalent to Executive 622 and has a complimentary chemistry to Alloy 622, yet provides the ease of welding and increased deposition rates associated with flux cored wire.

The high chromium content along with the molybdenum of Executive 56/21/14 results in good resistance to pitting and crevice corrosion. The wire possesses excellent weldability and can be used for the joining of ASTM B574, B575, B619, B622, and B628 having UNS number N06022. It can also be used in a wide variety of dissimilar welding applications including surfacing steel with nickel-chromium-molybdenum weld metal and cladding the side of joints in steels clad with nickel-chromium-molybdenum weld metal and even with high nitrogen containing stainless steels.

#### PROCEDURE

Keep preheat and post-heat to a minimum or according to base material. All best practices employed for the successful welding of high nickel alloys are to be followed.

#### TYPICAL CHEMICAL VALUES

C	Mn	Si	Cr	Ni	Mo	W	Fe	P	S
0.02	0.50	0.20	21.5	Bal	13.8	3.1	5.0	0.010	0.001

#### WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICK OUT	WIRE FEED SPEED	SHIELDING GAS
.045	25-26	140-210	1/2"	290-400 IPM	*100% CO <sub>2</sub> or 75%Argon-25%CO <sub>2</sub>
.062	26-27	180-260	1/2"	190-275 IPM	*100% CO <sub>2</sub> or 75%Argon-25%CO <sub>2</sub>

#### MECHANICAL PROPERTIES

Tensile Strength: 103,000 PSI (685 MPa)  
Yield Strength: 70,000 PSI (470 MPa)  
Elongation: 27%

#### CLASSIFICATION

The all weld metal deposit chemistry of this wire has been optimized for best performance and conforms to **AWS/SFA A5.34, Class ENiCrMo10T1-1/4**.