



DESCRIPTION

Executive 60/22/9 is a nickel-chromium-molybdenum gas shielded FCAW wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. It is the flux cored equivalent to Executive 625 and has a complimentary chemistry to Alloy 625 (NiCrMo-3), yet provides the ease of welding and increased deposition rates associated with flux cored wire.

The high alloy content of 60/22/9 enables it to withstand highly corrosive environments. The combination of nickel and chromium provides the resistance to oxidizing conditions and the combination of nickel and molybdenum provides resistance to reducing conditions. The increased level of molybdenum offers excellent resistance to stress corrosion cracking, pitting, and crevice corrosion in most applications. 60/22/9 is recommended for applications where the operating temperature ranges from cryogenic to 1000°F (540°C).

Executive 60/22/9 is a versatile filler metal that is used for welding of dissimilar joints between nickel-chrome-molybdenum alloys and stainless, carbon or low alloy steels. It is used extensively when welding various nickel alloys such as 9% nickel steel, Monel®, Inconel®, 254SMO, and AL-6XN. The iron content is restricted to 0.80 max to ensure the highest corrosion standard in overlaying applications.

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	CB	FE	P	S	AL	TI	CU
0.018	0.35	0.30	22.5	Bal	9.2	3.75	0.80	0.010	0.002	0.10	0.10	0.05

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICK OUT	WIRE FEED SPEED	SHIELDING GAS
.045	25-26	150-200	1/2"	290-400 IPM	*100% CO ₂ or 75%Argon-25%CO ₂
.062	26-27	190-280	1/2"	190-275 IPM	*100% CO ₂ or 75%Argon-25%CO ₂

MECHANICAL PROPERTIES

Tensile Strength: 110,000 PSI
Yield Strength: 72,000 PSI
Elongation: 38 %
Charpy Impact: 48 ft-lb at -320°F (-196°C)
Lateral Expansion: 35 mils

CLASSIFICATION

The all weld metal deposit chemistry of this wire has been optimized for best performance and conforms to **AWS/SFA A5.34, Class ENiCrMo3T1-1/4**.

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