



exocor™

Nickel BARE WIRE DATA SHEET

executive 60

DESCRIPTION

Executive 60 is a nickel-copper welding wire used for GTAW, GMAW and SAW welding of alloys ASTM B127, B163, B164, and B165 UNS Number N04400, and MONEL® 400, R-405, and K-500, and copper alloys. This filler metal can be used for GMAW overlay on steel after a first layer with Executive 61 (nickel 208). Dissimilar joining applications include nickel-copper alloys, carbon steel, low alloy steel to Nickel 200 and copper-nickel alloys. This product is widely used in marine applications because of its good resistance to the corrosive effects of seawater and brackish waters. Use Exocor 70/30 for all position FCAW applications.

TYPICAL CHEMICAL VALUES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	TOE
0.05	3.45	0.40	0.009	0.002	0.77	Rem	65.2	0.10	2.25	0.50

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.062	32 - 35	240 - 290	10 - 20 IPM	Record NiCuW
	.093	32 - 35	300 - 350	10 - 20 IPM	Record NiCuW
	.125	32 - 35	400 - 550	10 - 20 IPM	Record NiCuW
GMAW	.035	29 - 33	160 - 180	30 - 50 CFH	75% Argon+25% Helium
	.045	29 - 33	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	50% Argon + 50% Helium
GTAW	.093	Direct Current; Electrode –		30 - 40 CFH	100% Argon

MECHANICAL PROPERTIES

Tensile Strength:	76,500 PSI	530 MPA
Yield Strength:	52,500 PSI	360 MPA
Elongation:	34%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.14, Class ERNiCu-7**, ISO 18274, Class SNi 4060.

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