



DESCRIPTION

Executive 61 is nickel welding wire that is used for GMAW, GTAW, and SAW. The filler metal contains sufficient titanium to control weld-metal porosity with these welding processes. Executive 61 is also employed for overlaying on steel as well as repairing cast iron castings. It can also be used for dissimilar joints between nickels, or nickel alloys, to stainless or ferritic steels and is often used a buffer when surfacing with Executive 60.

Executive 61 is intended for welding wrought and cast forms of commercially pure nickel alloy including (ASTM B160, B161, B162 and B163 having UNS number N02200 or N02201).

TYPICAL CHEMICAL VALUES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	TOE
0.06	0.30	0.10	0.008	0.003	0.40	0.02	95.5	0.5	3.0	0.50

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.062	26 - 29	250 - 320	20 - 30 IPM	Record NiCrW
	.093	28 - 31	300 - 350	20 - 30 IPM	Record NiCrW
	.125	29 - 32	350 - 500	20 - 30 IPM	Record NiCrW
GMAW	.035	26 - 29	150 - 190	30 - 50 CFH	75% Argon+25% Helium
	.045	28 - 32	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:	66,500 PSI	460 MPA
Yield Strength:	38,000 PSI	260 MPA
Elongation:	28%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.14, Class ERNi-1**, ISO 18274, Class SNi 2061.