



DESCRIPTION

Executive 67 is a copper-nickel welding wire used for GTAW, GMAW, and SAW of 70/30, 80/20, and 90/10 copper-nickel alloys. The nickel addition strengthens the weld metal and improves the corrosion resistance, particularly against salt water.

This filler metal can be used for MIG overlay on steel after a first layer with Executive 61 and has good hot and cold ductility. In case of cladding on carbon steel, it is recommended to first deposit a nickel-copper buffer layer (*Executive 60* with *Record NiCuW* flux). Copper-nickel filler metals are used for welding most copper-nickel alloys and dissimilar-welding applications include joining copper-nickel alloys to Nickel 200 or nickel-copper alloys.

TYPICAL CHEMICAL VALUES

Cu incl. Ag	Mn	Fe	Si	Ni incl. Co	P	Pb	Ti	TOE
Remainder	0.75	0.55	0.10	31.0	0.006	0.02	0.35	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 CuNiW
	.093	28 - 31	300 - 350	20 - 30 IPM	Record CuNiW
	.125	29 - 32	350 - 500	20 - 30 IPM	Record CuNiW
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:	53,000 PSI	360 MPA
Yield Strength:	21,000 PSI	140 MPA
Elongation:	32%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.7, Class ERCuNi**.