executive

exocor™

Nickel FLUX CORED WIRE DATA SHEET

executive 69/15/2

DESCRIPTION

Executive 69/15/2 is a nickel-chromium-iron gas shielded flux cored wire that can be used for welding in all positions using 100% CO2 or Argon/CO2 mixtures. It is the flux cored equivalent to a SMAW **Type -A-** nickel alloy yet provides the ease of welding and increased deposition rates associated with flux cored wire. The weld puddle is more fluid then other forms of the alloy and the weld exhibits superior slag removal and outstanding bead appearance.

Executive 69/15/2 is used in the welding of (ASTM B163, B166, B167, and B168 having UNS Number N0660) to itself and an excellent choice for joining dissimilar alloys, i.e. nickel to stainless, stainless to carbon steels, Inconel® 600,601,690, alloy 800, 800HT; other Inconel® and Incoloy® alloys to carbon steel and stainless steel. It can also be used to join nickel and Monel® alloys, and Monel® alloys to carbon steel. It maintains strength and resists corrosion and oxidation from cryogenic service up to 1,800°F; however for temperatures above 1,500°F, Executive 69/15/2 does not exhibit optimum resistance and strength.

TYPICAL CHEMICAL VALUES

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Nb+Ta	Mo	T.O.E.
0.10	1.0-3.5	12.0	0.03	0.02	0.75	0.50	62.0 MIN	13.0-17.0	0.5-3.0	0.5-2.5	0.50

*single values shown are maximum percentages

WELDING PARAMETERS

Size	Volts	Amps	Stick out	Wire Feed Speed(ipm)	Shielding Gas
.045	25-26	150-200	1/2"	290-400	100% CO2 or 75%Argon-25%CO2
.062	26-27	200-250	1/2"	190-275	100% CO2 or 75%Argon-25%CO2

MECHANICAL PROPERTIES

Tensile Strength:	89,500 PSI	(595 MPA)
Yield Strength:	51,000 PSI	(340 MPA)
Elongation:	45 %	
Charpy Impact:	67 ft-lb at -320°F (-196°C)	
Lateral Expansion:	46 mils at -320°F (-196°C)	

CLASSIFICATION

The all weld metal deposit chemistry of this wire has been optimized for best performance and conforms to **AWS/SFA A5.34, Class ENiCrFe2T1-1/4.**