



Nickel FLUX CORED WIRE DATA SHEET

exocor 70/30

DESCRIPTION

Exocor 70/30 is a nickel base, copper-enriched 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 60 and has a matching chemistry to that of MONEL® 60, yet provides the ease of welding and increased deposition rates of a flux core wire.

Exocor 70/30 finds specific use as a welded overlay and joining alloy for resistance to corrosion from brackish water and reducing acids. Dissimilar joining applications include nickel-copper alloys, carbon steel, low alloy steel, MONEL® 400, R-405, and K-500, and copper alloys. It can be used for welding nickel-copper alloy ASTM B127, B163, B164, and B165 having UNS number N04400 to itself and for surfacing steel.

PROCEDURE

Keep preheat and post-heat to a minimum or according to base material. Apply Exocor 70/30 with stringer beads or a slight weave. The weld metal is suitable for service both in the as-welded condition and after an appropriate post weld heat treatment. All best practices employed for the successful welding of high nickel alloys are to be followed.

TYPICAL CHEMICAL VALUES

C	MN	FE	P	S	SI	CU	NI	AL	Ti	TOE
0.15	4.0	2.5	0.02	0.015	1.5	REM	62.0 - 69.0	0.75	1.0	0.50

*single values shown are maximum percentages

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICK OUT	SHIELDING GAS
.062"	22-30	200-300	5/8"	75%Argon-25%CO ₂

MECHANICAL PROPERTIES

Tensile Strength: 70,000 PSI minimum
Elongation: 30% minimum

CLASSIFICATION

This wire is not currently classified under **AWS/SFA A5.34**. The all weld metal deposit chemistry of this wire has been optimized for best performance to match its SMAW equivalent per **AWS/SFA A5.11, Class ENiCu-7**.

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