



exocor™

Nickel FLUX CORED WIRE DATA SHEET

executive 72/20/3

DESCRIPTION

Executive 72/20/3 is a nickel-chromium-iron 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 82 and has a complimentary chemistry to Alloy 82 (NiCr-3), yet provides the ease of welding and increased deposition rates associated with flux cored wire. The weld puddle is more fluid than other forms of the alloy and the weld exhibits superb slag removal and outstanding bead appearance.

Executive 72/20/3 is used in the welding of ASTM B163, B166, B167, and B168 having UNS Number N0660 and an excellent choice for joining dissimilar alloys, ie 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. Executive 72/20/3 can also be used to join nickel and Monel® alloys, and Monel alloys to carbon steel. It maintains strength and resists corrosion and oxidation up to 900°F and also is a suitable replacement for the fully austenitic filler metal 330 stainless in joining applications.

PROCEDURE

Keep preheat and post-heat to a minimum or according to base material. All best practices employed for the successful welding of high nickel alloys are to be followed.

TYPICAL CHEMICAL VALUES

C	MN	SI	CR	NI	CB	FE	P	S	TI	CU
0.020	2.90	0.30	20.00	BAL	2.40	1.7	0.010	0.003	0.10	0.10

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICK OUT	WIRE FEED SPEED	SHIELDING GAS
.045	25-26	140-210	1/2"	290-400 IPM	*100% CO ₂ or 75%Argon-25%CO ₂
.062	26-27	180-260	1/2"	190-275 IPM	*100% CO ₂ or 75%Argon-25%CO ₂

MECHANICAL PROPERTIES

Tensile Strength: 89,000 PSI (614 MPa)
Yield Strength: 58,000 PSI (400 MPa)
Elongation: 26 %

CLASSIFICATION

The all weld metal deposit chemistry of this wire has been optimized for best performance and conforms to **AWS/SFA A5.34, Class ENiCr3T1-1/4**.

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