



DESCRIPTION

Executive 99 is used for GTAW and GMAW welding of cast iron and is essentially composed of pure nickel with little deoxidization ability. This wire is extensively employed to repair gray iron castings. It can also be used for overlay and buildup. However, dilution from the casting influences the mechanical properties of the metal. The diluted welds are easily machinable. A preheat and interpass temperature of 350°F (175°C) minimum is recommended during welding.

TYPICAL CHEMICAL VALUES

C	Mn	Si	Ni	S	Fe	Cu	TOE
0.05	0.22	0.05	99.6	0.03	0.30	0.08	1.0

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.062	29 - 32	220 - 280	20 - 30 IPM	Please call
	.093	29 - 32	300 - 350	20 - 30 IPM	Please call
	.125	29 - 32	400 - 550	20 - 30 IPM	Please call
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:	66,500 PSI	460 MPA
Yield Strength:	36,000 PSI	250 MPA
Elongation:	40%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.15, Class ERNi-CI**.