

DESCRIPTION

Executive 67 is a copper-nickel alloy designed for welding Monel® 450 and other copper-nickel alloys using TIG, MIG and SAW welding processes. The high alloy content of Executive 67 produces a weld material with good hot and cold ductility along with excellent corrosion resistance in sea water.

Executive 67 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand.

APPLICATIONS & FEATURES

Executive 67 filler metal is used for welding Monel® 450 and most other copper-nickel alloys. It is also well suited for dissimilar joints including copper-nickel alloys to Nickel 200 or nickel-copper alloys.

Executive 67 is widely used for desalination plant components and parts in sea water service.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

Ni + Co	C	Mn	Fe	P	S	Si	Cu	Ti
31.5	0.01	0.76	0.58	0.007	0.001	0.10	67.00	0.31

Tensile Strength:	53,000 PSI Min	Yield Strength:	21,000 PSI Min	Elongation:	32%
--------------------------	----------------	------------------------	----------------	--------------------	-----

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar
	.045"	19-22	75-160		75% Ar / 25% He
	- Spray .045"	30-32	190-250		90% He / 7.5% Ar / 2.5% CO ₂
	- Pulse .045"	18-20	120-150		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.062"	28-32	250-280		CuNi-W Flux
	.093"	28-33	275-350		
	.125"	29-34	350-450		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	
	60-lb Acro Pak	

CLASSIFICATION

AWS/SFA 5.14, Class **ERCuNi**

