

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 Weld-A nickel alloy 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 superior slag removal and outstanding bead appearance.

Executive 69/15/2 maintains strength and resists corrosion and oxidation from cryogenic service up to 1,800°F (982°C); however for temperatures above 1,500°F (815°C), will not exhibit optimum resistance and strength.

APPLICATIONS & FEATURES

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.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Mo	Nb+Ta	TOE	
0.02	2.50	2.00	0.005	0.009	0.40	0.009	75.96	15.00	2.00	2.00	0.14	
Tensile Strength:		89,500 PSI min			Yield Strength:			51,000 PSI min		Elongation:		45%
Charpy Impact:		67 ft-lb at -320°F (-196°C)			Lateral Expansion:			46 Mills				

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed (in./min)	Stick-Out	Shielding Gas
.045"	25-26	140-210	290-400 IPM	1/2"	100% CO ₂ or 75% Ar / 25% CO ₂
.062"	26-27	180-260	190-275 IPM	1/2"	100% CO ₂ or 75% Ar / 25% CO ₂

STANDARD PACKAGING

Spools 33-lb wire baskets

CLASSIFICATION

AWS/SFA A5.34, Class **ENiCrFe2T1-1/4**

