

### DESCRIPTION

Executive 70/30 is a nickel base, copper-enriched gas shielded FCAW wire that is designed to be welded 75% Argon/25% CO<sub>2</sub>. It is the flux cored equivalent to Executive 60 and has a similar chemistry to that of MONEL® 60 (NiCu-7) providing ease of welding and increased deposition rates associated with flux cored wire.

The weld puddle for Executive 70/30 is more fluid than other forms of this alloy and the weld exhibits excellent slag release, superior bead appearance and offers great out of position welding results. The high alloy content of 70/30 produces weld material with good strength and corrosion resistance to reducing acids and seawater.

### APPLICATIONS & FEATURES

Executive 70/30 for joining MONEL® 400, R-405, and K-500, and copper alloys as well as dissimilar joints that include nickel-copper alloys, carbon steel and low alloy steel. The Executive 70/30 is also suited for overlay of steels that require corrosion resistance to salts, reducing acids and seawater.

### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	Fe	Ni	P	S	Cu	Al	Ti	
0.15	4.0	1.5	2.5	62.0-69.0	0.02	0.015	REM	0.75	1.0	
<b>Tensile Strength:</b>		70,000 PSI min					<b>Elongation:</b>		30%	

### 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"	75% Ar / 25% CO <sub>2</sub>
.062"	23-29	210-290	190-275 IPM	1/2"	75% Ar / 25% CO <sub>2</sub>

### STANDARD PACKAGING

**Spools**            33-lb wire baskets

### CLASSIFICATION

~AWS/SFA A5.11, Class **ENiCu-7**

