

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 such as 75/25. It is the flux cored equivalent to Executive 82 and has complimentary chemistry to Alloy 82 (NiCr-3) providing ease of welding and increased deposition rates associated with flux cored wire.

The weld puddle for Executive 72/20/3 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 72/20/3 produces high strength weld material with good corrosion resistance and strength at elevated service temperatures.

APPLICATIONS & FEATURES

Executive 72/20/3 is used for joining Inconel® 600, 601, 690, alloy 800, 800HT and is an excellent choice for joining dissimilar alloys, such as nickel to stainless and stainless to carbon steels. Executive 72/20/3 can also be used to join nickel and Monel® alloys as well as Monel alloys to carbon steel. It maintains strength and resists corrosion and oxidation up to 900°F and is also an excellent alternative to 330 stainless for joining applications.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

| C | Mn | Si | Cr | Ni | Cb | Fe | P | S | Ti | Cu |
|--------------------------|------|----------------|------|------------------------|------|----------------|-------|------------------------|------|------|
| 0.02 | 2.90 | 0.30 | 20.0 | BAL | 2.40 | 1.7 | 0.010 | 0.003 | 0.10 | 0.10 |
| Tensile Strength: | | 89,000 PSI min | | Yield Strength: | | 58,000 PSI min | | Elongation: 26% | | |

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 plastic spools

CLASSIFICATION

AWS/SFA A5.34, Class **ENiCr3T1-1/4**

