

DESCRIPTION

Executive 190 FC is a nickel base, copper-enriched gas shielded FCAW wire that is designed to be welded 75% Argon/25% CO₂. 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 190 FC 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 190 FC produces weld material with good strength and corrosion resistance to reducing acids and seawater.

APPLICATIONS & FEATURES

Executive 190 FC 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 190 FC 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 | |
| Tensile Strength: | | 70,000 PSI min | | | | | Elongation: | | 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 ₂ |
| .062" | 23-29 | 210-290 | 190-275 IPM | 1/2" | 75% Ar / 25% CO ₂ |

STANDARD PACKAGING

Spools 33-lb wire baskets

CLASSIFICATION

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

