

DESCRIPTION

Executive 82 is a nickel-chromium-iron alloy designed for welding alloys 600, 601, 690, alloy 800, 800HT using TIG, MIG and SAW welding processes. This alloy is also used for many dissimilar Inconel® alloy joints. The high alloy content of Executive 82 produces high strength weld material with good corrosion resistance and strength at elevated service temperatures.

Executive 82 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. Use Executive 72/20/3 where flux cored wire is suited to the application.

APPLICATIONS & FEATURES

Executive 82 is used for joining Inconel® and is an excellent choice for joining dissimilar alloys, such as nickel to stainless and stainless to carbon steels. Executive 82 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	Fe	P	S	Si	Cu	Ni	Al	Ti	Cr	Nb+Ta	Co
0.008	3.27	0.61	0.004	0.003	0.13	0.01	74.3	0.08	0.42	18.42	2.69	0.01

Tensile Strength: 86,000 PSI Min **Yield Strength:** 52,000 PSI Min **Elongation:** 38%

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
- Pulse	.045"	18-20	120-150		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.062"	28-32	250-280		NiCr-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 **ERNiCr-3**

Certified by the Canadian Welding Bureau (CWB) to AWS A5.14.