

DESCRIPTION

Executive 82 AP FC 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 82 AP 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 82 AP FC produces high strength weld material with good corrosion resistance and strength at elevated service temperatures.

APPLICATIONS & FEATURES

Executive 82 AP FC 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 82 AP FC 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 wire baskets

CLASSIFICATION

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

