

# Wire and Welding products

**HAYNES**  
Wire Company



## HAYNES® 625 RTW™ Filler Metal

### Product Description:

HAYNES® 625 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of alloys 625, 825 and a wide range of austenitic and super-austenitic stainless steels. The alloy is also used for cladding and overlay of carbon and stainless steels. The deposited weld metal has good resistance to localized corrosion, including pitting and crevice corrosion. The RTW™ filler metal finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

### Specifications:

AWS A5.14 ERNiCrMo-3	UNS N06625
ASME-SFA-5.14 ERNiCrMo-3	ASME IX F-43
AMS 5837	

### Weld Deposit Chemistry:

Ni	58.0 min.	Cu	0.50 max.
Cr	20.0 - 23.0	Other	0.50 max.
Mo	8.0 - 10.0	Al	0.40 max.
Fe	0.50 max.	Ti	0.40 max.
Nb+Ta	3.15 - 4.15	Co	0.10 max.
Mn	0.50 max.	P	0.02 max.
Si	0.50 max.	S	0.015 max.

### Minimum Mechanical Properties:

Tensile (psi)	115,000
Mpa	724
Elongation (%)	30

### Available Product Forms:

Diameter, in.	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
Diameter, mm.	0.8	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

Filler metals are available in spools and in cut lengths from the above diameters.

Straight lengths are available in 36" lengths.

HW-7011B

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