

# Wire and Welding products

**HAYNES**  
Wire Company



## **HAYNES® 200 RTW™ Filler Metal**

### **Product Description:**

HAYNES® 200 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of a variety of cast iron grades including gray, malleable and ductile. The weld deposits are easily machinable and can be deposited using a variety of processes. HAYNES® 200 grade is equivalent to filler metal 99 grades and can be used to weld cast iron materials to a variety of carbon steels. The RTW™ filler metal finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

### **Specifications:**

AWS A5.15 ERNi-CI  
ASME SFA5.15 ERNi-CI

UNS N02215

### **Weld Deposit Chemistry:**

Ni.....	99.0 min.	Si.....	0.35 max.
Fe.....	0.40 max.	S.....	0.01 max.
Cu.....	0.25 max.	C.....	0.015 max.
Mn.....	0.35 max.	Other.....	1.00 max.

### **Minimum Mechanical Properties:**

Tensile (psi)	71,000
Mpa	490
Elongation (%)	12

### **Available Product Forms:**

<b>Diameter in</b>	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
<b>Diameter mm</b>	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-7008B

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