

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® B-3® RTW™ Filler Metal

Product Description:

HASTELLOY® B-3® RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of B-3® alloy. The alloy has outstanding resistance to hydrochloric and sulfuric acids in the as-welded condition and excellent thermal stability. B-3® is a great candidate for overlay and cladding where resistance to hydrochloric and sulfuric acids is needed. 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 ERNiMo-10
ASME-SFA-5.14 ERNiMo-10
Kennblatt 7616.03

UNS N10675
Kennblatt 7615.02 (Spools)*

*Specify at time of order

Weld Deposit Chemistry:

Ni.....	65.0 min.	Al.....	0.50 max.
Mo.....	27.0 - 32.0	Other.....	0.50 max.
Co.....	3.0 max.	Ti.....	0.20 max.
Mn.....	3.0 max.	Cu.....	0.20 max.
Fe.....	1.0 - 3.0	Nb + Ta.....	0.20 max.
Cr.....	1.0 - 3.0	V.....	0.20 max.
W.....	3.0 max.	Si.....	0.10 max.
C.....	0.01 max.	P.....	0.03 max.
S.....	0.01 max.		

Minimum Mechanical Properties:

Tensile (psi)	110,000
Mpa	760
Elongation (%)	-

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-7015B

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