

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® G-30® RTW™ Filler Metal

Product Description:

HASTELLOY® G-30® RTW™ filler metal is used for gas metal arc, gas tungsten arc and submerged arc welding of G-30® alloy. G-30® alloy is also used for welding 6-7 molybdenum-bearing stainless steels and duplex grades including 2507. The alloy has many applications in phosphoric and nitric acid production, as well as, pulp and paper fabrications. G-30® alloy is considered an overmatching filler metal for the 6-7 molybdenum bearing stainless grades and also the duplex grades including 2507.

Specifications:

AWS A5.14 - ERNiCrMo-11

ASME SFA-5.14 - ERNiCrMo-11

Weld Deposit Chemistry:

Ni	Balance
Cr	28.0 - 31.5
Fe	13.0 - 17.0
Mo	4.0 - 6.0
Co	5.0 max.
W	1.5 - 4.0
Cu	1.0 - 2.4

Mn	1.50 max.
Si	0.80 max.
Other	0.50 max.
P	0.04 max.
C	0.03 max.
Su	0.02 max.

Minimum Mechanical Properties:

Tensile (psi)	85,000
Mpa	590
Elongation (%)	25

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-7032B

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