

Wire and Welding products

HAYNES
Wire Company



HAYNES® 230-W® RTW™ Filler Metal

Product Description:

HAYNES® 230-W RTW™ filler metal is used for the gas tungsten arc and gas metal arc welding of HAYNES® 230® alloy. The filler metal may also be used to weld UNS N06617. The deposited weld metal combines excellent high temperature strength and oxidation resistance with superior long term stability and good fabricability. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiCrWMo-1

ASME SFA-5.14 ERNiCrWMo-1

Weld Deposit Chemistry:

Ni	Remainder	Si	0.25 - 0.75
Cr	20.0 - 24.0	Al	0.20 - 0.50
W	13.0 - 15.0	Cu	0.50 max.
Co	5.0 max.	Other	0.50 max.
Fe	3.0 max.	C	0.05 - 0.15
Mo	1.00 - 3.00	P	0.03 max.
Mn	0.30 - 1.00	S	0.015 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-7043

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