

Wire and Welding products

HAYNES
Wire Company



ULTIMET[®] RTW[™] Filler Metal

Product Description:

ULTIMET[®] alloy RTW[™] filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of ULTIMET alloy. The weld metal is also used for the overlay and cladding of carbon and low alloy steels. The deposited weld metal excels where corrosion resistance is needed in conjunction with wear resistance. The weld deposits work harden very quickly and can achieve HRC 38-43 after cold work. In addition, it is very easy to deposit a "crack-free" layer without a butter layer. The RTW[™] filler metal finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

DIN CoCr26Ni9Mo5W
DIN No. 2.4681

UNS R31233

Weld Deposit Chemistry:

| | | | |
|---------|-------------|---------|-------------|
| Co..... | Balance | Si..... | 0.05 - 1.0 |
| Cr..... | 23.5 - 27.5 | N..... | 0.03 - 0.12 |
| Ni..... | 7.0 - 11.0 | C..... | 0.02 - 0.10 |
| Mo..... | 4.0 - 6.0 | P..... | 0.030 max. |
| Fe..... | 1.0 - 5.0 | S..... | 0.020 max. |
| W..... | 1.0 - 3.0 | B..... | 0.015 max. |
| Mn..... | 0.10 - 1.5 | | |

Minimum Mechanical Properties:

| | |
|----------------|---------|
| Tensile (psi) | 133,000 |
| Mpa | 917 |
| Elongation (%) | 10 |

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-7026B

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