

# Wire and Welding products

**HAYNES**  
International



## HASTELLOY® X RTW™ Filler Metal

### Product Description:

HASTELLOY® X RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of X alloy. The deposited weld metal has an exceptional combination of oxidation resistance, fabricability and high-temperature strength. It has also been found to be exceptionally resistant to stress-corrosion cracking in petrochemical applications. X alloy exhibits good ductility after prolonged exposure at temperatures of 1200, 1400, 1600°F (650, 760 and 870°C) for 16,000 hours. The filler metal is also a good candidate for dissimilar welding between solid solution nickel based alloys and Ni-Fe-Cr alloys. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

### Specifications:

AWS A5.14 ERNiCrMo-2

ASME SFA-5.14 ERNiCrMo-2

### Weld Deposit Chemistry:

Ni	Remainder
Cr	20.5 - 23.0
Fe	17.0 - 20.0
Mo	8.0 - 10.0
Co	0.50 - 2.50
Mn	1.00 max.
Si	0.50 max.

W	0.20 - 1.00
Cu	0.50 max.
Other	0.50 max.
C	0.05 - 0.15
P	0.04 max.
S	0.03 max.

### Minimum Mechanical Properties:

Tensile (psi)	95,000
Mpa	660
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-7042

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