

# Wire and Welding products

**HAYNES**  
Wire Company



## **HAYNES® 72 RTW™ Filler Metal**

### **Product Description:**

HAYNES® 72 RTW™ filler metal is used for the cladding and overlay of carbon and stainless steels where a nickel-chromium corrosion resistant surface is needed. The alloy can also be used in thermal spray applications. 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 ERNiCr-4  
ASME-SFA-5.14 ERNiCr-4

UNS N06072  
ASME IX F-43

### **Weld Deposit Chemistry:**

Ni.....	Balance	Si.....	0.20 max.
Cr.....	42.0 - 46.0	C.....	0.01 - 0.10
Ti.....	0.3 - 1.0	P.....	0.02 max.
Fe.....	0.50 max.	C.....	0.05 - 0.15
Cu.....	0.50 max.	S.....	0.015 max.
Other.....	0.50 max.		
Mn.....	0.20 max.		

### **Minimum Mechanical Properties:**

Tensile (psi)	106,000
Mpa	731
Elongation (%)	30

### **Available Product Forms:**

<b>Diameter in</b>	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
<b>Diameter mm</b>	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-7002B

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