

# Wire and Welding products

**HAYNES**  
Wire Company



## HAYNES® 617 RTW™ Filler Metal

### Product Description:

HAYNES® 617 RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of HAYNES® 617 alloy. The alloy has high temperature strength, good oxidation resistance and is used in many high temperature 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 ERNiCrCoMo-1  
ASME-SFA-5.14 ERNiCrCoMo-1  
AMS 5887

UNS N06617  
ASME IX F-43  
ASTM-B-166

### Weld Deposit Chemistry:

Ni.....Balance  
Cr.....20.0 - 24.0  
Co.....10.0 - 15.0  
Mo.....8.0-10.0  
Fe.....3.0 max.  
Al.....0.8 - 1.5  
Mn.....1.0 max.

Si.....1.0 max.  
Ti.....0.60 max.  
Cu.....0.50 max.  
Other.....0.50 max.  
C.....0.05 - 0.15  
P.....0.03 max.  
S.....0.015 max.

### Minimum Mechanical Properties:

Tensile (psi)           90,000  
Mpa                       620  
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-7010B

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