

# Wire and Welding products

**HAYNES**  
Wire Company



## **HAYNES® M413 RTW™ Filler Metal**

### **Product Description:**

HAYNES® M413 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of alloy 450 and other copper-nickel alloys. M413 has excellent resistance to sea water corrosion and can be used in marine environments where corrosion resistance is needed. The alloy can be used for the overlay and cladding of steels if a butter layer of ERNi-1 is first applied. The RTW™ filler metal finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

### **Specifications:**

AWS A5.7 ERCuNi  
ASME-SFA-5.7 ERCuNi

UNS C71580  
ASME IX F-34

### **Weld Deposit Chemistry:**

Cu including Ag.....	Balance	Other.....	0.50 max.
Ni including Co.....	29.0 - 32.0	Si.....	0.25 max.
Mn.....	1.0 max.	P.....	0.02 max.
Fe.....	0.40 - 0.75	Pb.....	0.02 max.
Ti.....	0.20 - 0.50	S.....	0.01 max.

### **Minimum Mechanical Properties:**

Tensile (psi)	50,000
Mpa	345
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-7022B

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