

Wire and Welding products

HAYNES
Wire Company



HAYNES® 418 RTW™ Filler Metal

Product Description:

HAYNES® M418 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of alloys M400, K-500 and other nickel-copper alloys. The weld metal has good corrosion resistance to many media including sea water and reducing acids. The alloy can be used for the overlay and cladding of steels, but care should be taken to determine if a butter layer of ERNi-1 is needed first. 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 ERNiCu-7
ASME-SFA-5.14 ERNiCu-7

UNS N04060
ASME IX F-42

Weld Deposit Chemistry:

Ni.....62.0 - 69.0
Cu.....Balance
Mn.....4.0 max.
Ti.....1.5 - 3.0
Fe.....2.5 max.
Si.....1.25 max.

Al.....1.25 max.
Other.....0.50 max.
C.....0.15 max.
P.....0.02 max.
S.....0.015 max.

Minimum Mechanical Properties:

Tensile (psi) 70,000
Mpa 483
Elongation (%) 30

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-7023B

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