

# Wire and Welding products

**HAYNES**  
Wire Company



## HAYNES® 25 Coated Electrodes

### Product Description:

HAYNES® 25 coated electrodes are used for the shielded metal arc welding of HAYNES® 25 alloy. The deposited weld metal has excellent strength, good oxidation resistance to 1800°F (980°C), very good sulfidation resistance, and relatively good resistance to wear and galling. The coating is designed for great operability, especially in out-of-position welding.

### Specifications:

AMS 5797

### Weld Deposit Chemistry:

Co.....Remainder  
Cr.....19.0 - 21.0  
W.....14.0 - 16.0  
Ni.....9.0 - 11.0  
Fe.....3.0 max.

Mn.....0.50 - 2.0  
Si.....1.0 max.  
C.....0.15 max.  
P.....0.03 max.  
S.....0.03 max.

### Minimum Mechanical Properties:

Tensile (psi)           100,000  
Mpa                       760  
Elongation (%)           35

### Available Product Forms:

Diameter (in)	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
Length (in)	10	14	14	14
Pkg Wt (lbs)	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7000

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