

# Wire and Welding products

**HAYNES**  
Wire Company



## HASTELLOY® G-35® Coated Electrodes

### Product Description:

HASTELLOY® G-35® coated electrodes are used for the shielded metal arc welding of G-35® alloy. The deposited weld metal has outstanding corrosion resistance to "wet process" phosphoric acid, other oxidizing acids, alkalis, and chloride-bearing media. The electrodes can also be used for the overlay and cladding of carbon steels where enhanced corrosion resistance is needed.

### Specifications:

AWS A5.11 ENiCrMo-22

UNS W86035

### Weld Deposit Chemistry:

Ni	Balance
Cr	32.25 - 34.25
Mo	7.6 - 9.0
Fe	2.0 max.
Co	1.0 max.
Mn	0.5 max.
Si	0.6 max.

C	0.05 max.
Cu	0.3 max.
Nb+Ta	0.50 max.
W	0.60 max.
Al	0.40 max.
Ti	0.20 max.
V	0.20 max.

P	0.03 max.
S	0.015 max.
Other	0.50 max.

### Minimum Mechanical Properties:

Tensile (psi)	85,000
Mpa	590
Elongation (%)	25

### Available Product Forms:

<b>Diameter, in.</b>	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
<b>Length, mm.</b>	10	14	14	14
<b>Package Weight, lbs.</b>	5	10	10	10
<b>Current (A) DCEP</b>	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7053

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