

# Wire and Welding products

**HAYNES**  
Wire Company



## HASTELLOY® X Coated Electrodes

### Product Description:

HASTELLOY® X coated electrodes are used for the shielded metal arc welding of X alloy. The deposited weld metal possesses an exceptional combination of oxidation resistance, fabricability and high-temperature strength. It has also been found to be exceptionally resistant to stress-corrosion cracking in petrochemical applications. X alloy exhibits good ductility after prolonged exposure at temperatures of 1200, 1400, 1600°F (650, 760 and 870°C) for 16,000 hours. The filler metal is often used as a dissimilar filler material between other solid-solution strengthened high temperature alloys.

### Specifications:

AWS A5.11 ENiCrMo-2

ASME-SFA-5.11 ENiCrMo-2

### Weld Deposit Chemistry:

Ni	Balance
Cr	20.5 - 23.0
Mo	17.0 - 20.0
Fe	0.5 - 2.5
Co	0.2 - 1.0
W	1.0 max.
Mn	1.0 max.

Si	1.0 max.
Cu	0.50 max.
Other	0.50 max.
C	0.05 - 0.15
S	0.03
P	0.04

### Minimum Mechanical Properties:

Tensile (psi)	95,000
Mpa	650
Elongation (%)	20

### Available Product Forms:

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

Packaged in Hermetically Sealed Containers

HW-7048

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