

Wire and Welding products

HAYNES
Wire Company



HAYNES® 230-W® Coated Electrodes

Product Description:

HAYNES® 230-W® Coated Electrodes are used for the shielded metal arc welding of HAYNES® 230® alloy. The deposited weld metal has excellent high temperature strength and outstanding resistance to oxidizing environments up to 2100°F for prolonged exposures. The deposited weld metal also has excellent long-term stability.

Specifications:

AWS A5.11 ENiCrWMo-1

UNS W86231

Weld Deposit Chemistry:

Ni	Remainder	Si	0.25 - 0.75	S	0.0015
Cr	20.00 - 24.00	Other	0.50 max.		
W	13.00 - 15.00	Cu	0.50 max.		
Co	5.00 max.	Al	0.50 max.		
Fe	3.00	Ti	0.10 max.		
Mo	1.00 - 3.00	C	0.10 max.		
Mn	0.30 - 1.00	P	0.02 max.		

Minimum Mechanical Properties:

Tensile (psi)	90,000
Mpa	620
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-7047

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